OM-1500-6 206 805K
2009–09

Processes

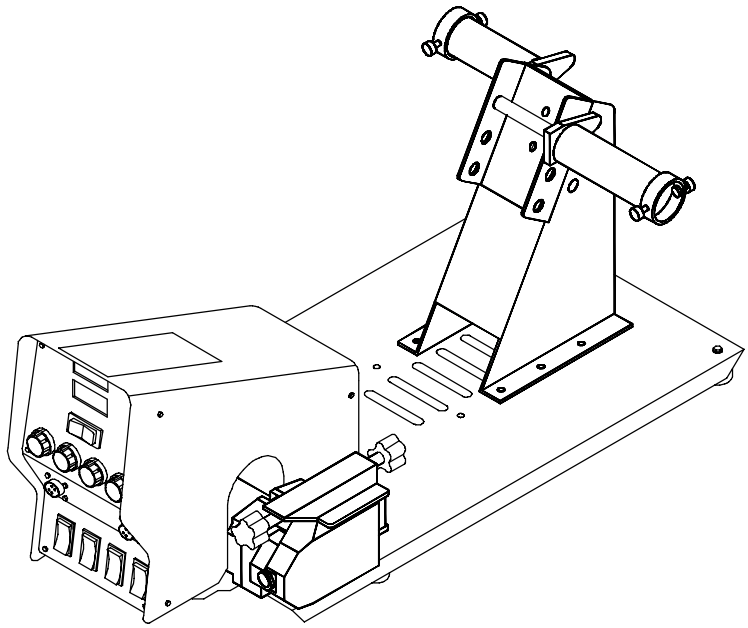
MIG (GMAW) Welding
Flux Cored (FCAW) Welding
(Gas- And Self-Shielded)

Description

CV

Wire Feeder

D-74S, D-74D CE



OWNER'S MANUAL

File: MIG (GMAW)

Visit our website at
www.MillerWelds.com

From Miller to You

Thank you and *congratulations* on choosing Miller. Now you can get the job done and get it done right. We know you don't have time to do it any other way.

That's why when Niels Miller first started building arc welders in 1929, he made sure his products offered long-lasting value and superior quality. Like you, his customers couldn't afford anything less. Miller products had to be more than the best they could be. They had to be the best you could buy.

Today, the people that build and sell Miller products continue the tradition. They're just as committed to providing equipment and service that meets the high standards of quality and value established in 1929.

This Owner's Manual is designed to help you get the most out of your Miller products. Please take time to read the Safety precautions. They will help you protect yourself against potential hazards on the worksite.

ISO 9001:2000 REGISTERED QUALITY SYSTEM

Miller is the first welding equipment manufacturer in the U.S.A. to be registered to the ISO 9001:2000 Quality System Standard.

We've made installation and operation quick and easy. With Miller you can count on years of reliable service with proper maintenance. And if for some reason the unit needs repair, there's a Troubleshooting section that will help you figure out what the problem is. The parts list will then help you to decide the exact part you may need to fix the problem. Warranty and service information for your particular model are also provided.

Miller Electric manufactures a full line of welders and welding related equipment. For information on other quality Miller products, contact your local Miller distributor to receive the latest full line catalog or individual specification sheets. **To locate your nearest distributor or service agency call 1-800-4-A-Miller, or visit us at www.MillerWelds.com on the web.**

TRUE BLUE® WARRANTY

Working as hard as you do – every power source from Miller is backed by the most hassle-free warranty in the business.

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WARRANTY

DECLARATION OF CONFORMITY

for European Community (CE marked) products.

MILLER Electric Mfg. Co., 1635 Spencer Street, Appleton, WI 54914 U.S.A. declares that the product(s) identified in this declaration conform to the essential requirements and provisions of the stated Council Directive(s) and Standard(s).

Product/Apparatus Identification:

Product	Stock Number
D-74S	195060 195060021 300328 300619
D-74D	195061 195061011 195061021 195061031 300620 300620001

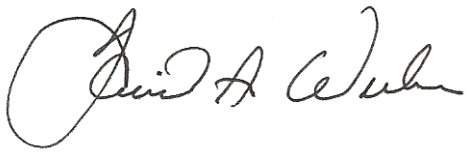
Council Directives:

- 2006/95/EC Low Voltage
- 2004/108/EC Electromagnetic Compatibility

Standards:

- IEC 60974-1:2005 Arc welding equipment – Part 1: Welding power sources
- IEC 60974-5:2007 Arc welding equipment – Part 5: Wire feeders
- IEC 60974-10:2007 Arc Welding Equipment – Part 10: Electromagnetic compatibility (EMC) requirements
- EN 50445:2008 Product family standard to demonstrate compliance of equipment for resistance welding, arc welding and allied processes with the basic restrictions related to human exposure to electromagnetic fields (0 Hz – 300Hz)

US Signatory:



August 31, 2009

David A. Werba — Date of Declaration

MANAGER, PRODUCT DESIGN COMPLIANCE

241321-B

SECTION 1 – SAFETY PRECAUTIONS - READ BEFORE USING

Protect yourself and others from injury — read and follow these precautions.

1-1. Symbol Usage

DANGER! – Indicates a hazardous situation which, if not avoided, will result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.

Indicates a hazardous situation which, if not avoided, could result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.

NOTICE *– Indicates statements not related to personal injury.*

☞ *Indicates special instructions.*

This group of symbols means Warning! Watch Out! ELECTRIC SHOCK, MOVING PARTS, and HOT PARTS hazards. Consult symbols and related instructions below for necessary actions to avoid the hazards.

1-2. Arc Welding Hazards

The symbols shown below are used throughout this manual to call attention to and identify possible hazards. When you see the symbol, watch out, and follow the related instructions to avoid the hazard. The safety information given below is only a summary of the more complete safety information found in the Safety Standards listed in Section 1-5. Read and follow all Safety Standards.

Only qualified persons should install, operate, maintain, and repair this unit.

During operation, keep everybody, especially children, away.

ELECTRIC SHOCK can kill.

Touching live electrical parts can cause fatal shocks or severe burns. The electrode and work circuit is electrically live whenever the output is on. The input power circuit and machine internal circuits are also live when power is on. In semiautomatic or automatic wire welding, the wire, wire reel, drive roll housing, and all metal parts touching the welding wire are electrically live. Incorrectly installed or improperly grounded equipment is a hazard.

- Do not touch live electrical parts.
- Wear dry, hole-free insulating gloves and body protection.
- Insulate yourself from work and ground using dry insulating mats or covers big enough to prevent any physical contact with the work or ground.
- Do not use AC output in damp areas, if movement is confined, or if there is a danger of falling.
- Use AC output ONLY if required for the welding process.
- If AC output is required, use remote output control if present on unit.
- Additional safety precautions are required when any of the following electrically hazardous conditions are present: in damp locations or while wearing wet clothing; on metal structures such as floors, gratings, or scaffolds; when in cramped positions such as sitting, kneeling, or lying; or when there is a high risk of unavoidable or accidental contact with the workpiece or ground. For these conditions, use the following equipment in order presented: 1) a semiautomatic DC constant voltage (wire) welder, 2) a DC manual (stick) welder, or 3) an AC welder with reduced open-circuit voltage. In most situations, use of a DC, constant voltage wire welder is recommended. And, do not work alone!
- Disconnect input power or stop engine before installing or servicing this equipment. Lockout/tagout input power according to OSHA 29 CFR 1910.147 (see Safety Standards).
- Properly install and ground this equipment according to its Owner's Manual and national, state, and local codes.
- Always verify the supply ground – check and be sure that input power cord ground wire is properly connected to ground terminal in disconnect box or that cord plug is connected to a properly grounded receptacle outlet.
- When making input connections, attach proper grounding conductor first – double-check connections.
- Keep cords dry, free of oil and grease, and protected from hot metal and sparks.
- Frequently inspect input power cord for damage or bare wiring – replace cord immediately if damaged – bare wiring can kill.
- Turn off all equipment when not in use.
- Do not use worn, damaged, undersized, or poorly spliced cables.
- Do not drape cables over your body.
- If earth grounding of the workpiece is required, ground it directly with a separate cable.
- Do not touch electrode if you are in contact with the work, ground, or another electrode from a different machine.
- Do not touch electrode holders connected to two welding machines at the same time since double open-circuit voltage will be present.
- Use only well-maintained equipment. Repair or replace damaged parts at once. Maintain unit according to manual.
- Wear a safety harness if working above floor level.
- Keep all panels and covers securely in place.
- Clamp work cable with good metal-to-metal contact to workpiece or worktable as near the weld as practical.
- Insulate work clamp when not connected to workpiece to prevent contact with any metal object.
- Do not connect more than one electrode or work cable to any single weld output terminal.

SIGNIFICANT DC VOLTAGE exists in inverter welding power sources AFTER removal of inputpower.

- Turn Off inverter, disconnect input power, and discharge input capacitors according to instructions in Maintenance Section before touching any parts.

HOT PARTS can burn.

- Do not touch hot parts bare handed.
- Allow cooling period before working on equipment.
- To handle hot parts, use proper tools and/or wear heavy, insulated welding gloves and clothing to prevent burns.

FUMES AND GASES can be hazardous.

Welding produces fumes and gases. Breathing these fumes and gases can be hazardous to your health.

- Keep your head out of the fumes. Do not breathe the fumes.
- If inside, ventilate the area and/or use local forced ventilation at the arc to remove welding fumes and gases.
- If ventilation is poor, wear an approved air-supplied respirator.
- Read and understand the Material Safety Data Sheets (MSDSs) and the manufacturer's instructions for metals, consumables, coatings, cleaners, and degreasers.
- Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator. Always have a trained watch-person nearby. Welding fumes and gases can displace air and lower the oxygen level causing injury or death. Be sure the breathing air is safe.
- Do not weld in locations near degreasing, cleaning, or spraying operations. The heat and rays of the arc can react with vapors to form highly toxic and irritating gases.
- Do not weld on coated metals, such as galvanized, lead, or cadmium plated steel, unless the coating is removed from the weld area, the area is well ventilated, and while wearing an air-supplied respirator. The coatings and any metals containing these elements can give off toxic fumes if welded.

ARC RAYS can burn eyes and skin.

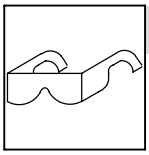
Arc rays from the welding process produce intense visible and invisible (ultraviolet and infrared) rays that can burn eyes and skin. Sparks fly off from the weld.

- Wear an approved welding helmet fitted with a proper shade of filter lenses to protect your face and eyes from arc rays and sparks when welding or watching (see ANSI Z49.1 and Z87.1 listed in Safety Standards).
- Wear approved safety glasses with side shields under your helmet.
- Use protective screens or barriers to protect others from flash, glare and sparks; warn others not to watch the arc.
- Wear protective clothing made from durable, flame-resistant material (leather, heavy cotton, or wool) and foot protection.

WELDING can cause fire or explosion.

Welding on closed containers, such as tanks, drums, or pipes, can cause them to blow up. Sparks can fly off from the welding arc. The flying sparks, hot workpiece, and hot equipment can cause fires and burns. Accidental contact of electrode to metal objects can cause sparks, explosion, overheating, or fire. Check and be sure the area is safe before doing any welding.

- Remove all flammables within 35 ft (10.7 m) of the welding arc. If this is not possible, tightly cover them with approved covers.
- Do not weld where flying sparks can strike flammable material.
- Protect yourself and others from flying sparks and hot metal.
- Be alert that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas.
- Watch for fire, and keep a fire extinguisher nearby.
- Be aware that welding on a ceiling, floor, bulkhead, or partition can cause fire on the hidden side.
- Do not weld on closed containers such as tanks, drums, or pipes, unless they are properly prepared according to AWS F4.1 (see Safety Standards).
- Do not weld where the atmosphere may contain flammable dust, gas, or liquid vapors (such as gasoline).
- Connect work cable to the work as close to the welding area as practical to prevent welding current from traveling long, possibly unknown paths and causing electric shock, sparks, and fire hazards.
- Do not use welder to thaw frozen pipes.
- Remove stick electrode from holder or cut off welding wire at contact tip when not in use.
- Wear oil-free protective garments such as leather gloves, heavy shirt, cuffless trousers, high shoes, and a cap.
- Remove any combustibles, such as a butane lighter or matches, from your person before doing any welding.
- After completion of work, inspect area to ensure it is free of sparks, glowing embers, and flames.
- Use only correct fuses or circuit breakers. Do not oversize or by-pass them.
- Follow requirements in OSHA 1910.252 (a) (2) (iv) and NFPA 51B for hot work and have a fire watcher and extinguisher nearby.



FLYING METAL or DIRT can injure eyes.

- Welding, chipping, wire brushing, and grinding cause sparks and flying metal. As welds cool, they can throw off slag.
- Wear approved safety glasses with side shields even under your welding helmet.

BUILDUP OF GAS can injure or kill.

- Shut off shielding gas supply when not in use.
- Always ventilate confined spaces or use approved air-supplied respirator.

ELECTRIC AND MAGNETIC FIELDS (EMF) can affect ImplantedMedical Devices.

- Wearers of Pacemakers and other Implanted Medical Devices should keep away.
- Implanted Medical Device wearers should consult their doctor and the device manufacturer before going near arc welding, spot welding, gouging, plasma arc cutting, or induction heating operations.

NOISE can damage hearing.

Noise from some processes or equipment can damage hearing.

- Wear approved ear protection if noise level is high.

CYLINDERS can explode if damaged.

Shielding gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. Since gas cylinders are normally part of the welding process, be sure to treat them carefully.

- Protect compressed gas cylinders from excessive heat, mechanical shocks, physical damage, slag, open flames, sparks, and arcs.
- Install cylinders in an upright position by securing to a stationary support or cylinder rack to prevent falling or tipping.
- Keep cylinders away from any welding or other electrical circuits.
- Never drape a welding torch over a gas cylinder.
- Never allow a welding electrode to touch any cylinder.
- Never weld on a pressurized cylinder – explosion will result.
- Use only correct shielding gas cylinders, regulators, hoses, and fittings designed for the specific application; maintain them and associated parts in good condition.
- Turn face away from valve outlet when opening cylinder valve.
- Keep protective cap in place over valve except when cylinder is in use or connected for use.
- Use the right equipment, correct procedures, and sufficient number of persons to lift and move cylinders.
- Read and follow instructions on compressed gas cylinders, associated equipment, and Compressed Gas Association (CGA) publication P-1 listed in Safety Standards.

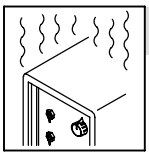
1-3. Additional Symbols For Installation, Operation, And Maintenance

FIRE OR EXPLOSION hazard.

- Do not install or place unit on, over, or near combustible surfaces.
- Do not install unit near flammables.
- Do not overload building wiring – be sure power supply system is properly sized, rated, and protected to handle this unit.

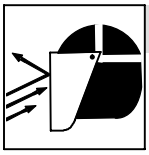
FALLING EQUIPMENT can injure.

- Use lifting eye to lift unit only, NOT running gear, gas cylinders, or any other accessories.
- Use equipment of adequate capacity to lift and support unit.
- If using lift forks to move unit, be sure forks are long enough to extend beyond opposite side of unit.
- Keep equipment (cables and cords) away from moving vehicles when working from an aerial location.
- Follow the guidelines in the Applications Manual for the Revised NIOSH Lifting Equation (Publication No. 94–110) when manually lifting heavy parts or equipment.



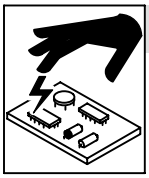
OVERUSE can cause OVERHEATING

- Allow cooling period; follow rated duty cycle.
- Reduce current or reduce duty cycle before starting to weld again.
- Do not block or filter airflow to unit.



FLYING SPARKS can injure.

- Wear a face shield to protect eyes and face.
- Shape tungsten electrode only on grinder with proper guards in a safe location wearing proper face, hand, and body protection.
- Sparks can cause fires — keep flammables away.



STATIC (ESD) can damage PC boards.

- Put on grounded wrist strap BEFORE handling boards or parts.
- Use proper static-proof bags and boxes to store, move, or ship PC boards.

MOVING PARTS can injure.

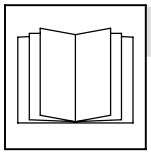
- Keep away from moving parts.
- Keep away from pinch points such as drive rolls.

WELDING WIRE can injure.

- Do not press gun trigger until instructed to do so.
- Do not point gun toward any part of the body, other people, or any metal when threading welding wire.

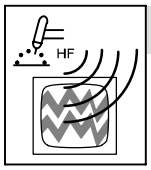
MOVING PARTS can injure.

- Keep away from moving parts such as fans.
- Keep all doors, panels, covers, and guards closed and securely in place.
- Have only qualified persons remove doors, panels, covers, or guards for maintenance and troubleshooting as necessary.
- Reinstall doors, panels, covers, or guards when maintenance is finished and before reconnecting input power.



READ INSTRUCTIONS.

- Read and follow all labels and the Owner's Manual carefully before installing, operating, or servicing unit. Read the safety information at the beginning of the manual and in each section.
- Use only genuine replacement parts from the manufacturer.
- Perform maintenance and service according to the Owner's Manuals, industry standards, and national, state, and local codes.



H.F. RADIATION can cause interference.

- High-frequency (H.F.) can interfere with radio navigation, safety services, computers, and communications equipment.
- Have only qualified persons familiar with electronic equipment perform this installation.
- The user is responsible for having a qualified electrician promptly correct any interference problem resulting from the installation.
- If notified by the FCC about interference, stop using the equipment at once.
- Have the installation regularly checked and maintained.
- Keep high-frequency source doors and panels tightly shut, keep spark gaps at correct setting, and use grounding and shielding to minimize the possibility of interference.

ARC WELDING can cause interference.

- Electromagnetic energy can interfere with sensitive electronic equipment such as computers and computer-driven equipment such as robots.
- Be sure all equipment in the welding area is electromagnetically compatible.
- To reduce possible interference, keep weld cables as short as possible, close together, and down low, such as on the floor.
- Locate welding operation 100 meters from any sensitive electronic equipment.
- Be sure this welding machine is installed and grounded according to this manual.
- If interference still occurs, the user must take extra measures such as moving the welding machine, using shielded cables, using line filters, or shielding the work area.

1-4. California Proposition 65 Warnings

Welding or cutting equipment produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety Code Section 25249.5 et seq.)

Battery posts, terminals and related accessories contain lead and lead compounds, chemicals known to the State of California to cause cancer and birth defects or other reproductive harm. Wash hands after handling.

For Gasoline Engines:

Engine exhaust contains chemicals known to the State of California to cause cancer, birth defects, or other reproductive harm.

For Diesel Engines:

Diesel engine exhaust and some of its constituents are known to the State of California to cause cancer, birth defects, and other reproductive harm.

1-5. Principal Safety Standards

Safety in Welding, Cutting, and Allied Processes, ANSI Standard Z49.1, from Global Engineering Documents (phone: 1-877-413-5184, website: www.global.ihs.com).

Safe Practices for the Preparation of Containers and Piping for Welding and Cutting, American Welding Society Standard AWS F4.1, from Global Engineering Documents (phone: 1-877-413-5184, website: www.global.ihs.com).

National Electrical Code, NFPA Standard 70, from National Fire Protection Association, Quincy, MA 02269 (phone: 1-800-344-3555, website: www.nfpa.org and www. sparky.org).

Safe Handling of Compressed Gases in Cylinders, CGA Pamphlet P-1, from Compressed Gas Association, 4221 Walney Road, 5th Floor, Chantilly, VA 20151 (phone: 703-788-2700, website:www.cganet.com).

Safety in Welding, Cutting, and Allied Processes, CSA Standard W117.2, from Canadian Standards Association, Standards Sales, 5060 Spectrum Way, Suite 100, Ontario, Canada L4W 5NS (phone: 800-463-6727, website: www.csa-international.org).

Safe Practice For Occupational And Educational Eye And Face Protection, ANSI Standard Z87.1, from American National Standards Institute, 25 West 43rd Street, New York, NY 10036 (phone: 212-642-4900, website: www.ansi.org).

Standard for Fire Prevention During Welding, Cutting, and Other Hot Work, NFPA Standard 51B, from National Fire Protection Association, Quincy, MA 02269 (phone: 1-800-344-3555, website: www.nfpa.org.

OSHA, Occupational Safety and Health Standards for General Industry, Title 29, Code of Federal Regulations (CFR), Part 1910, Subpart Q, and Part 1926, Subpart J, from U.S. Government Printing Office, Superintendent of Documents, P.O. Box 371954, Pittsburgh, PA 15250-7954 (phone: 1-866-512-1800) (there are 10 OSHA Regional Offices—phone for Region 5, Chicago, is 312-353-2220, website: www.osha.gov).

U.S. Consumer Product Safety Commission (CPSC), 4330 East West Highway, Bethesda, MD 20814 (phone: 301-504-7923, website: www.cpsc.gov).

Applications Manual for the Revised NIOSH Lifting Equation, The National Institute for Occupational Safety and Health (NIOSH), 1600 Clifton Rd, Atlanta, GA 30333 (phone: 1-800-232-4636, website: www.cdc.gov/NIOSH).

1-6. EMF Information

Electric current flowing through any conductor causes localized electric and magnetic fields (EMF). Welding current creates an EMF field around the welding circuit and welding equipment. EMF fields may interfere with some medical implants, e.g. pacemakers. Protective measures for persons wearing medical implants have to be taken. For example, access restrictions for passers–by or individual risk assessment for welders. All welders should use the following procedures in order to minimize exposure to EMF fields from the welding circuit:

1. Keep cables close together by twisting or taping them, or using a cable cover.
2. Do not place your body between welding cables. Arrange cables to one side and away from the operator.
3. Do not coil or drape cables around your body.
4. Keep head and trunk as far away from the equipment in the welding circuit as possible.
5. Connect work clamp to workpiece as close to the weld as possible.
6. Do not work next to, sit or lean on the welding power source.
7. Do not weld whilst carrying the welding power source or wire feeder.

About Implanted Medical Devices:

Implanted Medical Device wearers should consult their doctor and the device manufacturer before performing or going near arc welding, spot welding, gouging, plasma arc cutting, or induction heating operations. If cleared by your doctor, then following the above procedures is recommended.

SECTION 2 – CONSIGNES DE SÉCURITÉ – LIRE AVANT UTILISATION

Se protéger et protéger les autres contre le risque de blessure — lire et respecter ces consignes.

2-1. Symboles utilisés

DANGER! – Indique une situation dangereuse qui si on l'évite pas peut donner la mort ou des blessures graves. Les dangers possibles sont montrés par les symboles joints ou sont expliqués dans le texte.

Indique une situation dangereuse qui si on l'évite pas peut donner la mort ou des blessures graves. Les dangers possibles sont montrés par les symboles joints ou sont expliqués dans le texte.

NOTE *– Indique des déclarations pas en relation avec des blessures personnelles.*

☞ *Indique des instructions spécifiques.*

Ce groupe de symboles veut dire Avertissement! Attention! DANGER DE CHOC ELECTRIQUE, PIECES EN MOUVEMENT, et PIECES CHAUDES. Consulter les symboles et les instructions ci-dessous y afférant pour les actions nécessaires afin d'éviter le danger.

2-2. Dangers relatifs au soudage à l'arc

Les symboles représentés ci-dessous sont utilisés dans ce manuel pour attirer l'attention et identifier les dangers possibles. En présence de l'un de ces symboles, prendre garde et suivre les instructions afférentes pour éviter tout risque. Les instructions en matière de sécurité indiquées ci-dessous ne constituent qu'un sommaire des instructions de sécurité plus complètes fournies dans les normes de sécurité énumérées dans la Section 2-5. Lire et observer toutes les normes de sécurité.

Seul un personnel qualifié est autorisé à installer, faire fonctionner, entretenir et réparer cet appareil.

Pendant le fonctionnement, maintenir à distance toutes les personnes, notamment les enfants de l'appareil.

UNE DÉCHARGE ÉLECTRIQUE peut entraîner la mort.

Le contact d'organes électriques sous tension peut provoquer des accidents mortels ou des brûlures graves. Le circuit de l'électrode et de la pièce est sous tension lorsque le courant est délivré à la sortie. Le circuit d'alimentation et les circuits internes de la machine sont également sous tension lorsque l'alimentation est sur Marche. Dans le mode de soudage avec du fil, le fil, le dérouleur, le bloc de commande du rouleau et toutes les parties métalliques en contact avec le fil sont sous tension électrique. Un équipement installé ou mis à la terre de manière incorrecte ou impropre constitue un danger.

- Ne pas toucher aux pièces électriques sous tension.
- Porter des gants isolants et des vêtements de protection secs et sans trous.
- S'isoler de la pièce à couper et du sol en utilisant des housses ou des tapis assez grands afin d'éviter tout contact physique avec la pièce à couper ou le sol.
- Ne pas se servir de source électrique à courant électrique dans les zones humides, dans les endroits confinés ou là où on risque de tomber.
- Se servir d'une source électrique à courant électrique UNIQUEMENT si le procédé de soudage le demande.
- Si l'utilisation d'une source électrique à courant électrique s'avère nécessaire, se servir de la fonction de télécommande si l'appareil en est équipé.
- D'autres consignes de sécurité sont nécessaires dans les conditions suivantes : risques électriques dans un environnement humide ou si l'on porte des vêtements mouillés ; sur des structures métalliques telles que sols, grilles ou échafaudages ; en position coincée comme assise, à genoux ou couchée ; ou s'il y a un risque élevé de contact inévitable ou accidentel avec la pièce à souder ou le sol. Dans ces conditions, utiliser les équipements suivants, dans l'ordre indiqué : 1) un poste à souder DC à tension constante (à fil), 2) un poste à souder DC manuel (électrode) ou 3) un poste à souder AC à tension à vide réduite. Dans la plupart des situations, l'utilisation d'un poste à souder DC à fil à tension constante est recommandée. En outre, ne pas travailler seul !
- Couper l'alimentation ou arrêter le moteur avant de procéder à l'installation, à la réparation ou à l'entretien de l'appareil. Déverrouiller l'alimentation selon la norme OSHA 29 CFR 1910.147 (voir normes de sécurité).
- Installer le poste correctement et le mettre à la terre convenablement selon les consignes du manuel de l'opérateur et les normes nationales, provinciales et locales.
- Toujours vérifier la terre du cordon d'alimentation. Vérifier et s'assurer que le fil de terre du cordon d'alimentation est bien raccordé à la borne de terre du sectionneur ou que la fiche du cordon est raccordée à une prise correctement mise à la terre.
- En effectuant les raccordements d'entrée, fixer d'abord le conducteur de mise à la terre approprié et contre-vérifier les connexions.
- Les câbles doivent être exempts d'humidité, d'huile et de graisse; protégez–les contre les étincelles et les pièces métalliques chaudes.
- Vérifier fréquemment le cordon d'alimentation afin de s'assurer qu'il n'est pas altéré ou à nu, le remplacer immédiatement s'il l'est. Un fil à nu peut entraîner la mort.
- L'équipement doit être hors tension lorsqu'il n'est pas utilisé.
- Ne pas utiliser des câbles usés, endommagés, de grosseur insuffisante ou mal épissés.
- Ne pas enrouler les câbles autour du corps.
- Si la pièce soudée doit être mise à la terre, le faire directement avec un câble distinct.
- Ne pas toucher l'électrode quand on est en contact avec la pièce, la terre ou une électrode provenant d'une autre machine.
- Ne pas toucher des porte électrodes connectés à deux machines en même temps à cause de la présence d'une tension à vide doublée.
- N'utiliser qu'un matériel en bon état. Réparer ou remplacer sur-le-champ les pièces endommagées. Entretenir l'appareil conformément à ce manuel.
- Porter un harnais de sécurité si l'on doit travailler au-dessus du sol.
- S'assurer que tous les panneaux et couvercles sont correctement en place.
- Fixer le câble de retour de façon à obtenir un bon contact métal-métal avec la pièce à souder ou la table de travail, le plus près possible de la soudure.
- Isoler la pince de masse quand pas mis à la pièce pour éviter le contact avec tout objet métallique.
- Ne pas raccorder plus d'une électrode ou plus d'un câble de masse à une même borne de sortie de soudage.

Il reste une TENSION DC NON NÉGLIGEABLE dans les sources de soudage onduleur UNE FOIS l'alimentation coupée.

- Arrêter les convertisseurs, débrancher le courant électrique et décharger les condensateurs d'alimentation selon les instructions indiquées dans la partie Entretien avant de toucher les pièces.

LES PIÈCES CHAUDES peuvent provoquer des brûlures.

- Ne pas toucher à mains nues les parties chaudes.
- Prévoir une période de refroidissement avant de travailler à l'équipement.
- Ne pas toucher aux pièces chaudes, utiliser les outils recommandés et porter des gants de soudage et des vêtements épais pour éviter les brûlures.

LES FUMÉES ET LES GAZ peuvent être dangereux.

Le soudage génère des fumées et des gaz. Leur inhalation peut être dangereux pour votre santé.

- Eloigner votre tête des fumées. Ne pas respirer les fumées.
- À l'intérieur, ventiler la zone et/ou utiliser une ventilation forcée au niveau de l'arc pour l'évacuation des fumées et des gaz de soudage.
- Si la ventilation est médiocre, porter un respirateur anti-vapeurs approuvé.
- Lire et comprendre les spécifications de sécurité des matériaux (MSDS) et les instructions du fabricant concernant les métaux, les consommables, les revêtements, les nettoyants et les dégraisseurs.
- Travailler dans un espace fermé seulement s'il est bien ventilé ou en portant un respirateur à alimentation d'air. Demander toujours à un surveillant dûment formé de se tenir à proximité. Des fumées et des gaz de soudage peuvent déplacer l'air et abaisser le niveau d'oxygène provoquant des blessures ou des accidents mortels. S'assurer que l'air de respiration ne présente aucun danger.
- Ne pas souder dans des endroits situés à proximité d'opérations de dégraissage, de nettoyage ou de pulvérisation. La chaleur et les rayons de l'arc peuvent réagir en présence de vapeurs et former des gaz hautement toxiques et irritants.
- Ne pas souder des métaux munis d'un revêtement, tels que l'acier galvanisé, plaqué en plomb ou au cadmium à moins que le revêtement n'ait été enlevé dans la zone de soudure, que l'endroit soit bien ventilé, et en portant un respirateur à alimentation d'air. Les revêtements et tous les métaux renfermant ces éléments peuvent dégager des fumées toxiques en cas de soudage.

LES RAYONS DE L'ARC peuvent provoquer des brûlures dans les yeux et sur la peau.

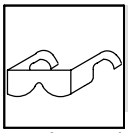
Le rayonnement de l'arc du procédé de soudag génère des rayons visibles et invisibles intense (ultraviolets et infrarouges) susceptibles de provoquer des brûlure dans les yeux et sur la peau. Des étincelles sont projetées pendant l soudage.

- Porter un casque de soudage approuvé muni de verres filtrants approprié pour protéger visage et yeux pour protéger votre visage et vos yeux pendant le soudage ou pour regarder (voir ANSI Z49.1 et Z87.1 énuméré dans les normes de sécurité).
- Porter des lunettes de sécurité avec écrans latéraux même sous votre casque.
- Avoir recours à des écrans protecteurs ou à des rideaux pour protéger les autres contre les rayonnements les éblouissements et les étincelles ; prévenir toute personne sur les lieux de ne pas regarder l'arc.
- Porter des vêtements confectionnés avec des matières résistantes et ignifuges (cuir, coton lourd ou laine) et des bottes de protection.

LE SOUDAGE peut provoquer un incendie ou une explosion.

Le soudage effectué sur des conteneurs fermés tels que des réservoirs, tambours ou des conduites peut provoquer leur éclatement. Des étincelles peuvent être projetées de l'arc de soudure. La projection d'étincelles, des pièces chaudes et des équipements chauds peut provoquer des incendies et des brûlures. Le contact accidentel de l'électrode avec des objets métalliques peut provoquer des étincelles, une explosion, un surchauffement ou un incendie. Avant de commencer le soudage, vérifier et s'assurer que l'endroit ne présente pas de danger.

- Déplacer toutes les substances inflammables à une distance de 10,7 m de l'arc de soudage. En cas d'impossibilité les recouvrir soigneusement avec des protections homologués.
- Ne pas souder dans un endroit là où des étincelles peuvent tomber sur des substances inflammables.
- Se protéger et d'autres personnes de la projection d'étincelles et de métal chaud.
- Des étincelles et des matériaux chauds du soudage peuvent facilement passer dans d'autres zones en traversant de petites fissures et des ouvertures.
- Surveiller tout déclenchement d'incendie et tenir un extincteur à proximité.
- Le soudage effectué sur un plafond, plancher, paroi ou séparation peut déclencher un incendie de l'autre côté.
- Ne pas effectuer le soudage sur des conteneurs fermés tels que des réservoirs, tambours, ou conduites, à moins qu'ils n'aient été préparés correctement conformément à AWS F4.1 (voir les normes de sécurité).
- Ne soudez pas si l'air ambiant est chargé de particules, gaz, ou vapeurs inflammables (vapeur d'essence, par exemple).
- Brancher le câble de masse sur la pièce le plus près possible de la zone de soudage pour éviter le transport du courant sur une longue distance par des chemins inconnus éventuels en provoquant des risques d'électrocution, d'étincelles et d'incendie.
- Ne pas utiliser le poste de soudage pour dégeler des conduites gelées.
- En cas de non utilisation, enlever la baguette d'électrode du porte-électrode ou couper le fil à la pointe de contact.
- Porter des vêtements de protection dépourvus d'huile tels que des gants en cuir, une chemise en matériau lourd, des pantalons sans revers, des chaussures hautes et un couvre chef.
- Avant de souder, retirer toute substance combustible de vos poches telles qu'un allumeur au butane ou des allumettes.
- Une fois le travail achevé, assurez–vous qu'il ne reste aucune trace d'étincelles incandescentes ni de flammes.
- Utiliser exclusivement des fusibles ou coupe–circuits appropriés. Ne pas augmenter leur puissance; ne pas les ponter.
- Une fois le travail achevé, assurez–vous qu'il ne reste aucune trace d'étincelles incandescentes ni de flammes.
- Utiliser exclusivement des fusibles ou coupe–circuits appropriés. Ne pas augmenter leur puissance; ne pas les ponter.
- Suivre les recommandations dans OSHA 1910.252(a)(2)(iv) et NFPA 51B pour les travaux à chaud et avoir de la surveillance et un extincteur à proximité.



DES PIECES DE METAL ou DES SALETES peuvent provoquer des blessures dans les yeux.

- Le soudage, l'écaillement, le passage de la pièce à la brosse en fil de fer, et le meulage génèrent des étincelles et des particules métalliques volantes. Pendant la période de refroidissement des soudures, elles risquent de projeter du laitier.
- Porter des lunettes de sécurité avec écrans latéraux ou un écran facial.

LES ACCUMULATIONS DE GAZ risquent de provoquer des blessures ou même la mort.

- Fermer l'alimentation du gaz protecteur en cas de non-utilisation.
- Veiller toujours à bien aérer les espaces confinés ou se servir d'un respirateur d'adduction d'air homologué.

Les CHAMPS ÉLECTROMAGNÉTIQUES (CEM) peuvent affecter les implants médicaux.

- Les porteurs de stimulateurs cardiaques et autres implants médicaux doivent rester à distance.
- Les porteurs d'implants médicaux doivent consulter leur médecin et le fabricant du dispositif avant de s'approcher de la zone où se déroule du soudage à l'arc, du soudage par points, du gougeage, de la découpe plasma ou une opération de chauffage par induction.

LE BRUIT peut endommager l'ouïe.

Le bruit des processus et des équipements peut affecter l'ouïe.

- Porter des protections approuvées pour les oreilles si le niveau sonore est trop élevé.

LES BOUTEILLES peuvent exploser si elles sont endommagées.

Des bouteilles de gaz protecteur contiennent du gaz sous haute pression. Si une bouteille est endommagée, elle peut exploser. Du fait que les bouteilles de gaz font normalement partie du procédé de soudage, les manipuler avec précaution.

- Protéger les bouteilles de gaz comprimé d'une chaleur excessive, des chocs mécaniques, des dommages physiques, du laitier, des flammes ouvertes, des étincelles et des arcs.
- Placer les bouteilles debout en les fixant dans un support stationnaire ou dans un porte-bouteilles pour les empêcher de tomber ou de se renverser.
- Tenir les bouteilles éloignées des circuits de soudage ou autres circuits électriques.
- Ne jamais placer une torche de soudage sur une bouteille à gaz.
- Une électrode de soudage ne doit jamais entrer en contact avec une bouteille.
- Ne jamais souder une bouteille pressurisée – risque d'explosion.
- Utiliser seulement des bouteilles de gaz protecteur, régulateurs, tuyaux et raccords convenables pour cette application spécifique ; les maintenir ainsi que les éléments associés en bon état.
- Détourner votre visage du détendeur-régulateur lorsque vous ouvrez la soupape de la bouteille.
- Le couvercle du détendeur doit toujours être en place, sauf lorsque la bouteille est utilisée ou qu'elle est reliée pour usage ultérieur.
- Utiliser les équipements corrects, les bonnes procédures et suffisamment de personnes pour soulever et déplacer les bouteilles.
- Lire et suivre les instructions sur les bouteilles de gaz comprimé, l'équipement connexe et le dépliant P-1 de la CGA (Compressed Gas Association) mentionné dans les principales normes de sécurité.

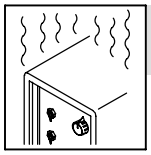
2-3. Dangers supplémentaires en relation avec l'installation, le fonctionnement et la maintenance

Risque D'INCENDIE OU D'EXPLOSION.

- Ne pas placer l'appareil sur, au-dessus ou à proximité de surfaces inflammables.
- Ne pas installer l'appareil à proximité de produits inflammables.
- Ne pas surcharger l'installation électrique – s'assurer que l'alimentation est correctement dimensionnée et protégée avant de mettre l'appareil en service.

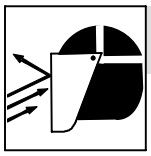
LA CHUTE DE L'ÉQUIPEMENT peut provoquer des blessures.

- Utiliser l'anneau de levage uniquement pour soulever l'appareil, NON PAS les chariots, les bouteilles de gaz ou tout autre accessoire.
- Utiliser un équipement de levage de capacité suffisante pour lever l'appareil.
- En utilisant des fourches de levage pour déplacer l'unité, s'assurer que les fourches sont suffisamment longues pour dépasser du côté opposé de l'appareil.
- Tenir l'équipement (câbles et cordons) à distance des véhicules mobiles lors de toute opération en hauteur.
- Suivre les consignes du Manuel des applications pour l'équation de levage NIOSH révisée (Publication Nº94–110) lors du levage manuelle de pièces ou équipements lourds.



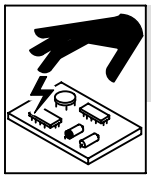
L'EMPLOI EXCESSIF peut SURCHAUFFER L'ÉQUIPEMENT.

- Prévoir une période de refroidissement ; respecter le cycle opératoire nominal.
- Réduire le courant ou le facteur de marche avant de poursuivre le soudage.
- Ne pas obstruer les passages d'air du poste.



LES ÉTINCELLES PROJETÉES peuvent provoquer des blessures.

- Porter un écran facial pour protéger le visage et les yeux.
- Affûter l'électrode au tungstène uniquement à la meuleuse dotée de protecteurs. Cette manœuvre est à exécuter dans un endroit sûr lorsque l'on porte l'équipement homologué de protection du visage, des mains et du corps.
- Les étincelles risquent de causer un incendie – éloigner toute substance inflammable.



LES CHARGES ÉLECTROSTATIQUES peuvent endommager les circuits imprimés.

- Établir la connexion avec la barrette de terre avant de manipuler des cartes ou des pièces.
- Utiliser des pochettes et des boîtes antistatiques pour stocker, déplacer ou expédier des cartes de circuits imprimes.

Les PIÈCES MOBILES peuvent causer des blessures.

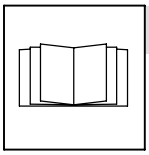
- Ne pas s'approcher des organes mobiles.
- Ne pas s'approcher des points de coincement tels que des rouleaux de commande.

LES FILS DE SOUDAGE peuvent provoquer des blessures.

- Ne pas appuyer sur la gâchette avant d'en avoir reçu l'instruction.
- Ne pas diriger le pistolet vers soi, d'autres personnes ou toute pièce mécanique en engageant le fil de soudage.

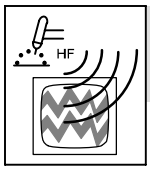
Les PIÈCES MOBILES peuvent causer des blessures.

- S'abstenir de toucher des organes mobiles tels que des ventilateurs.
- Maintenir fermés et verrouillés les portes, panneaux, recouvrements et dispositifs de protection.
- Lorsque cela est nécessaire pour des travaux d'entretien et de dépannage, faire retirer les portes, panneaux, recouvrements ou dispositifs de protection uniquement par du personnel qualifié.
- Remettre les portes, panneaux, recouvrements ou dispositifs de protection quand l'entretien est terminé et avant de rebrancher l'alimentation électrique.



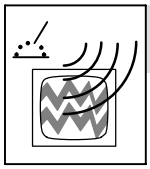
LIRE LES INSTRUCTIONS.

- Lire et appliquer les instructions sur les étiquettes et le Mode d'emploi avant l'installation, l'utilisation ou l'entretien de l'appareil. Lire les informations de sécurité au début du manuel et dans chaque section.
- N'utiliser que les pièces de rechange recommandées par le constructeur.
- Effectuer l'entretien en respectant les manuels d'utilisation, les normes industrielles et les codes nationaux, d'état et locaux.



LE RAYONNEMENT HAUTE FRÉQUENCE (H.F.) risque de provoquer des interférences.

- Le rayonnement haute fréquence (H.F.) peut provoquer des interférences avec les équipements de radio–navigation et de communication, les services de sécurité et les ordinateurs.
- Demander seulement à des personnes qualifiées familiarisées avec des équipements électroniques de faire fonctionner l'installation.
- L'utilisateur est tenu de faire corriger rapidement par un électricien qualifié les interférences résultant de l'installation.
- Si le FCC signale des interférences, arrêter immédiatement l'appareil.
- Effectuer régulièrement le contrôle et l'entretien de l'installation.
- Maintenir soigneusement fermés les portes et les panneaux des sources de haute fréquence, maintenir les éclateurs à une distance correcte et utiliser une terre et un blindage pour réduire les interférences éventuelles.



LE SOUDAGE À L'ARC risque de provoquer des interférences.

- L'énergie électromagnétique risque de provoquer des interférences pour l'équipement électronique sensible tel que les ordinateurs et l'équipement commandé par ordinateur tel que les robots.
- Veiller à ce que tout l'équipement de la zone de soudage soit compatible électromagnétiquement.
- Pour réduire la possibilité d'interférence, maintenir les câbles de soudage aussi courts que possible, les grouper, et les poser aussi bas que possible (ex. par terre).
- Veiller à souder à une distance de 100 mètres de tout équipement électronique sensible.
- Veiller à ce que ce poste de soudage soit posé et mis à la terre conformément à ce mode d'emploi.
- En cas d'interférences après avoir pris les mesures précédentes, il incombe à l'utilisateur de prendre des mesures supplémentaires telles que le déplacement du poste, l'utilisation de câbles blindés, l'utilisation de filtres de ligne ou la pose de protecteurs dans la zone de travail.

2-4. Proposition californienne 65 Avertissements

⚠ Les équipements de soudage et de coupage produisent des fumées et des gaz qui contiennent des produits chimiques dont l'État de Californie reconnaît qu'ils provoquent des malformations congénitales et, dans certains cas, des cancers. (Code de santé et de sécurité de Californie, chapitre 25249.5 et suivants)

⚠ Les batteries, les bornes et autres accessoires contiennent du plomb et des composés à base de plomb, produits chimiques dont l'État de Californie reconnaît qu'ils provoquent des cancers et des malformations congénitales ou autres problèmes de procréation. Se laver les mains après manipulation.

Pour les moteurs à essence :

⚠ Les gaz d'échappement des moteurs contiennent des produits chimiques dont l'État de Californie reconnaît qu'ils provoquent des cancers et des malformations congénitales ou autres problèmes de procréation.

Pour les moteurs diesel :

⚠ Les gaz d'échappement des moteurs diesel et certains de leurs composants sont reconnus par l'État de Californie comme provoquant des cancers et des malformations congénitales ou autres problèmes de procréation.

2-5. Principales normes de sécurité

Safety in Welding, Cutting, and Allied Processes, ANSI Standard Z49.1, de Global Engineering Documents (téléphone : 1-877-413-5184, site Internet : www.global.ihs.com).

Safe Practices for the Preparation of Containers and Piping for Welding and Cutting, American Welding Society Standard AWS F4.1, de Global Engineering Documents (téléphone : 1-877-413-5184, site internet : www.global.ihs.com).

National Electrical Code, NFPA Standard 70, de National Fire Protection Association, Quincy, MA 02269 (téléphone : 800-344-3555, site Internet : www.nfpa.org et www.sparky.org).

Safe Handling of Compressed Gases in Cylinders, CGA Pamphlet P-1, de Compressed Gas Association, 4221 Walney Road, 5th Floor, Chantilly, VA 20151 (téléphone : 703-788-2700, site Internet : www.cganet.com).

Safety in Welding, Cutting, and Allied Processes, CSA Standard W117.2, de Canadian Standards Association, Standards Sales, 5060 Spectrum Way, Suite 100, Ontario, Canada L4W 5NS (téléphone : 800-463-6727, site internet : www.csa-international.org).

Safe Practice For Occupational And Educational Eye And Face Protection, ANSI Standard Z87.1, de American National Standards Institute, 25 West 43rd Street, New York, NY 10036 (téléphone : 212-642-4900, site Internet : www.ansi.org).

Standard for Fire Prevention During Welding, Cutting, and Other Hot Work, NFPA Standard 51B, de National Fire Protection Association, P.O. Box 9101, Quincy, MA 02269-9101 (téléphone : 617-770-3000, site Internet : www.nfpa.org).

OSHA, Occupational Safety and Health Standards for General Industry, Title 29, Code of Federal Regulations (CFR), Part 1910, Subpart Q, and Part 1926, Subpart J, de U.S. Government Printing Office, Superintendent of Documents, P.O. Box 371954, Pittsburgh, PA 15250-7954 (téléphone : 1-866-512-1800) (il y a 10 bureaux régionaux–le téléphone de la région 5, Chicago, est 312-353-2220, site Internet : www.osha.gov).

U.S. Consumer Product Safety Commission (CPSC), 4330 East West Highway, Bethesda, MD 20814 (téléphone : 301-504-7923, site internet : www.cpsc.gov).

Applications Manual for the Revised NIOSH Lifting Equation, The National Institute for Occupational Safety and Health (NIOSH), 1600 Clifton Rd, Atlanta, GA 30333 (télé[hone : 1-800-232-4636, site internet: www.cdc.gov/NIOSH).

2-6. Informations relatives aux CEM

Le courant électrique qui traverse tout conducteur génère des champs électromagnétiques (CEM) à certains endroits. Le courant de soudage crée un CEM autour du circuit et du matériel de soudage. Les CEM peuvent créer des interférences avec certains implants médicaux comme des stimulateurs cardiaques. Des mesures de protection pour les porteurs d'implants médicaux doivent être prises: par exemple, des restrictions d'accès pour les passants ou une évaluation individuelle des risques pour les soudeurs. Tous les soudeurs doivent appliquer les procédures suivantes pour minimiser l'exposition aux CEM provenant du circuit de soudage:

1 Rassembler les câbles en les torsadant ou en les attachant avec du ruban adhésif ou avec une housse.

2 Ne pas se tenir au milieu des câbles de soudage. Disposer les câbles d'un côté et à distance de l'opérateur.

3 Ne pas courber et ne pas entourer les câbles autour de votre corps.

4 Maintenir la tête et le torse aussi loin que possible du matériel du circuit de soudage.

5 Connecter la pince sur la pièce aussi près que possible de la soudure.

6 Ne pas travailler à proximité d'une source de soudage, ni s'asseoir ou se pencher dessus.

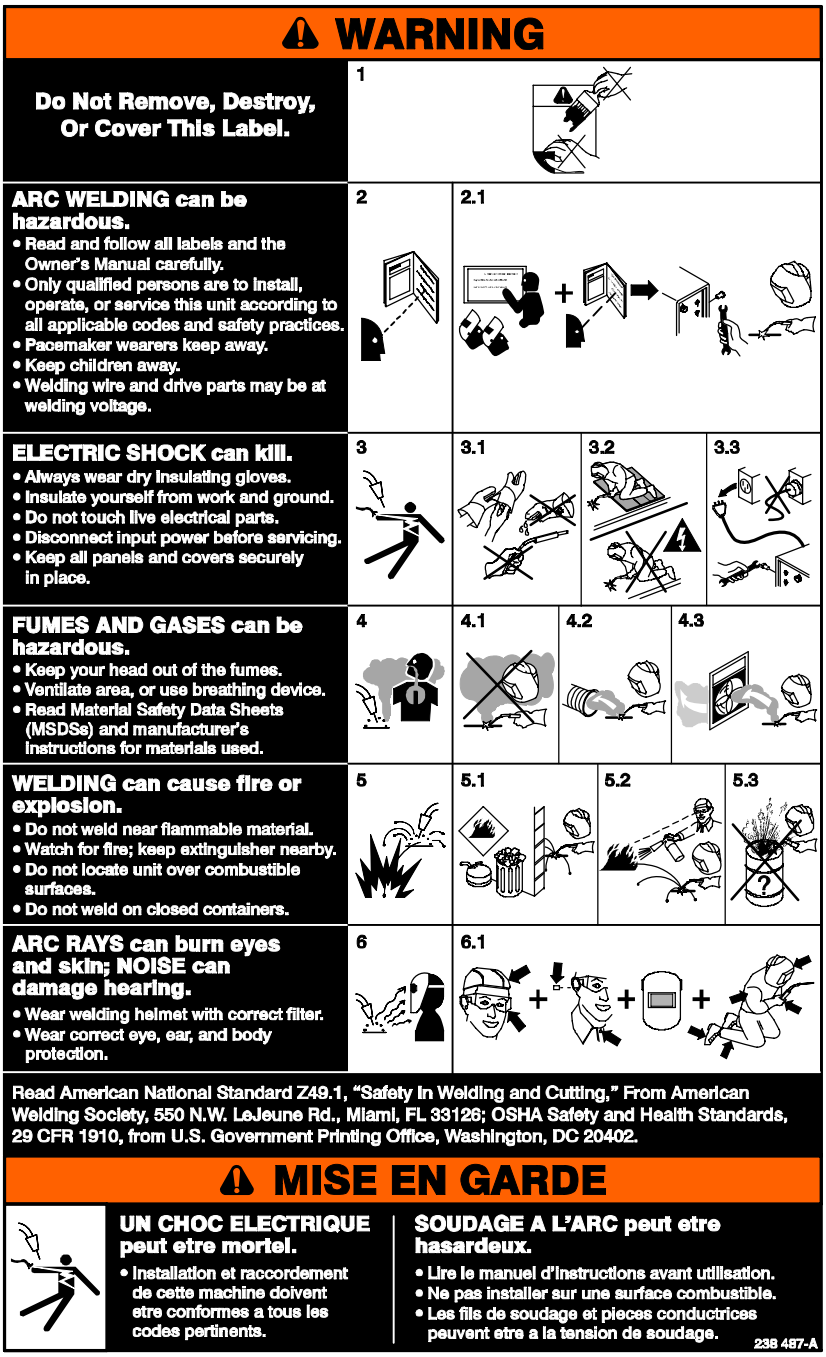
7 Ne pas souder tout en portant la source de soudage ou le dévidoir.

En ce qui concerne les implants médicaux :

Les porteurs d'implants doivent d'abord consulter leur médecin avant de s'approcher des opérations de soudage à l'arc, de soudage par points, de gougeage, du coupage plasma ou de chauffage par induction. Si le médecin approuve, il est recommandé de suivre les procédures précédentes.

SECTION 3 – DEFINITIONS

3-1. Warning Label Definitions


WARNING
Do Not Remove, Destroy, Or Cover This Label.
1
ARC WELDING can be hazardous.
• Read and follow all labels and the Owner's Manual carefully.
• Only qualified persons are to install, operate, or service this unit according to all applicable codes and safety practices.
• Pacemaker wearers keep away.
• Keep children away.
• Welding wire and drive parts may be at welding voltage.
2
2.1
ELECTRIC SHOCK can kill.
• Always wear dry insulating gloves.
• Insulate yourself from work and ground.
• Do not touch live electrical parts.
• Disconnect input power before servicing.
• Keep all panels and covers securely in place.
3
3.1
3.2
3.3
FUMES AND GASES can be hazardous.
• Keep your head out of the fumes.
• Ventilate area, or use breathing device.
• Read Material Safety Data Sheets (MSDSs) and manufacturer's instructions for materials used.
4
4.1
4.2
4.3
WELDING can cause fire or explosion.
• Do not weld near flammable material.
• Watch for fire; keep extinguisher nearby.
• Do not locate unit over combustible surfaces.
• Do not weld on closed containers.
5
5.1
5.2
5.3
ARC RAYS can burn eyes and skin; NOISE can damage hearing.
• Wear welding helmet with correct filter.
• Wear correct eye, ear, and body protection.
6
6.1
Read American National Standard Z49.1, "Safety in Welding and Cutting," From American Welding Society, 550 N.W. LeJeune Rd., Miami, FL 33126; OSHA Safety and Health Standards, 29 CFR 1910, from U.S. Government Printing Office, Washington, DC 20402.
MISE EN GARDE
UN CHOC ELECTRIQUE peut etre mortel.
• Installation et raccordement de cette machine doivent etre conformes a tous les codes pertinents.
SOUDAGE A L'ARC peut etre hasardeux.
• Lire le manuel d'instructions avant utilisation.
• Ne pas installer sur une surface combustible.
• Les fils de soudage et pieces conductrices peuvent etre a la tension de soudage.
238 487-A

1 Do not remove or paint over (cover) the label.

2 Always read and follow the Owner's Manual.

2.1 Become trained and read the instructions before working on the machine or welding.

3 Electric shock can kill.

3.1 Wear dry insulating gloves. Do not touch electrode with bare hand. Do not wear wet or damaged gloves.

3.2 Protect yourself from electric shock by insulating yourself from work and ground.

3.3 Disconnect input plug or power before working on machine.

4 Breathing welding fumes can be hazardous to your health.

4.1 Keep your head out of the fumes.

4.2 Use forced ventilation or local exhaust to remove the fumes.

4.3 Use ventilating fan to remove fumes.

5 Welding sparks can cause explosion or fire.

5.1 Keep flammables away from welding. Don't weld near flammables.

5.2 Welding sparks can cause fires. Have a fire extinguisher nearby and have a watch person ready to use it.

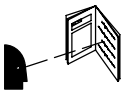
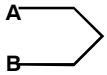
5.3 Do not weld on drums or any closed containers.

6 Arc rays can burn eyes and injure skin.

6.1 Wear hat and safety glasses. Use ear protection and button shirt collar. Use welding helmet with correct shade of filter. Wear complete body protection.

3-2. Symbols And Definitions

☞ *Some symbols are found only on CE products.*

A	Amperes	V	Volts		Alternating Current	X	Duty Cycle
IP	Degree Of Protection	Hz	Hertz		Program		Wire Feed
	Jog		Output		Trigger		Line Connection
	Set Up		Sequence		Trigger Hold On		Trigger Hold Off
	Purge		Press To Set		Start		Crater
t	Time		Preflow Time		Postflow Time		Read Instructions
	Increase	I_1	Primary Current	I_2	Rated Current	U_2	Load Voltage
U_1	Primary Voltage		Dual Schedule				

SECTION 4 – INTRODUCTION

4-1. Specifications

Type of Input Power	Welding Power Source Type	Wire Feed Speed Range	Wire Diameter Range	Welding Circuit Rating	IP Rating	Overall Dimensions	Weight
24 Volts AC Single-Phase 10 Amperes 50/60 Hertz	Constant Voltage (CV) DC With 14-Pin And Contactor Control	Standard: 50 To 780 ipm (1.3 To 19.8 mpm) Optional High Speed: 92 To 1435 ipm (2.3 To 36.4 mpm)	.023 To 1/8 in (0.6 To 3.2 mm) Max Spool Weight: 60 lb (27 kg)	100 Volts, 750 Amperes, 100% Duty Cycle	IP 21	Length: 35 in (889 mm) Width: 12-1/2 in (318 mm) Height: 14 in (356 mm)	87 lb (39.5 kg)

SECTION 5 – INSTALLATION

5-1. Important Information Regarding CE Products (Sold Within The EU)

This equipment shall not be used by the general public as the EMF limits for the general public might be exceeded during welding.

This equipment is built in accordance with EN 60974–1 and is intended to be used only in an occupational environment (where the general public access is prohibited or regulated in such a way as to be similar to occupational use) by an expert or an instructed person.

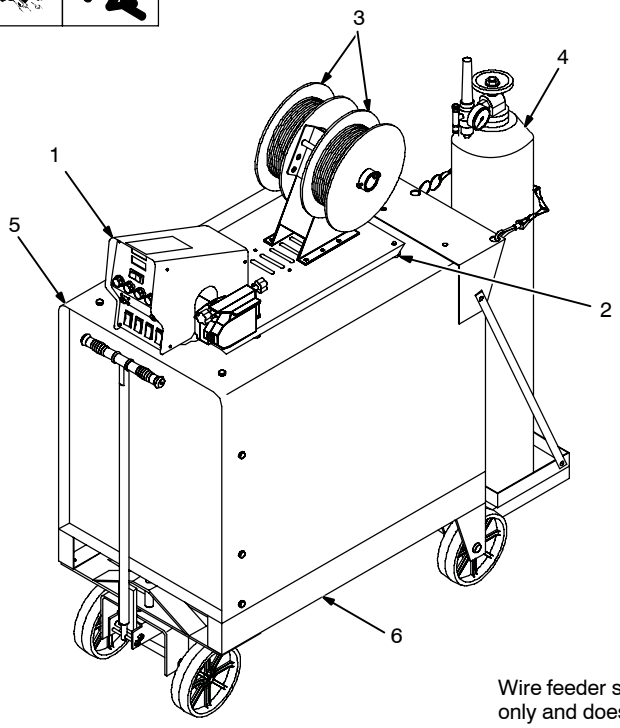
Wire feeders and ancillary equipment (such as torches, liquid cooling systems and arc striking and stabilizing devices) as part of the welding circuit may not be a major contributor to the EMF. See the Owner's Manuals for all components of the welding circuit for additional EMF exposure information.

- The EMF assessment on this equipment was conducted at 0.5 meter.
- At a distance of 1 meter the EMF exposure values were less than 20% of the permissible values.

5-2. Serial Number And Rating Label Location

The serial number and rating information for this product is located on the rear panel. Use rating label to determine input power requirements and/or rated output. For future reference, write serial number in space provided on back cover of this manual.

5-3. Site Selection



Do not put feeder where welding wire hits cylinder.

Do not move or operate equipment when it could tip.

1 Wire Feeder

2 Rubber Feet

Choose slot that allows all rubber feet to sit securely on top of welding power source.

3 Wire Spool/Reels

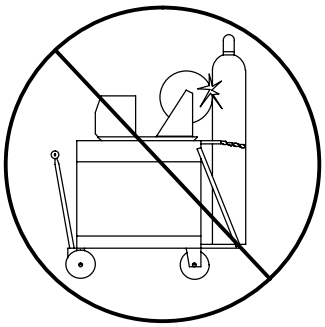
4 Gas Cylinder w/Hose And Regulator (Customer Supplied)

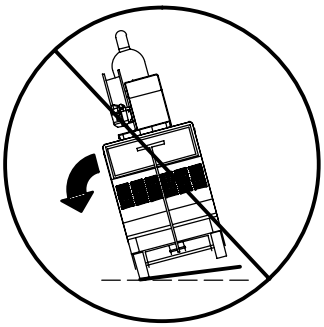
☞ *Shielding gas pressure not to exceed 100 PSI (689 kPa).*

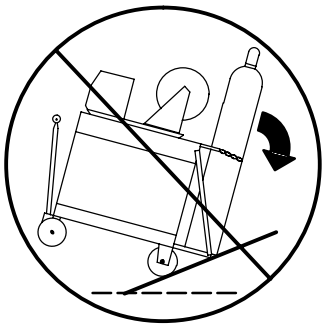
5 Welding Power Source

6 Running Gear

Wire feeder shown is representative only and does not reflect actual unit.

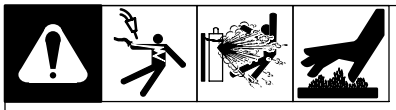






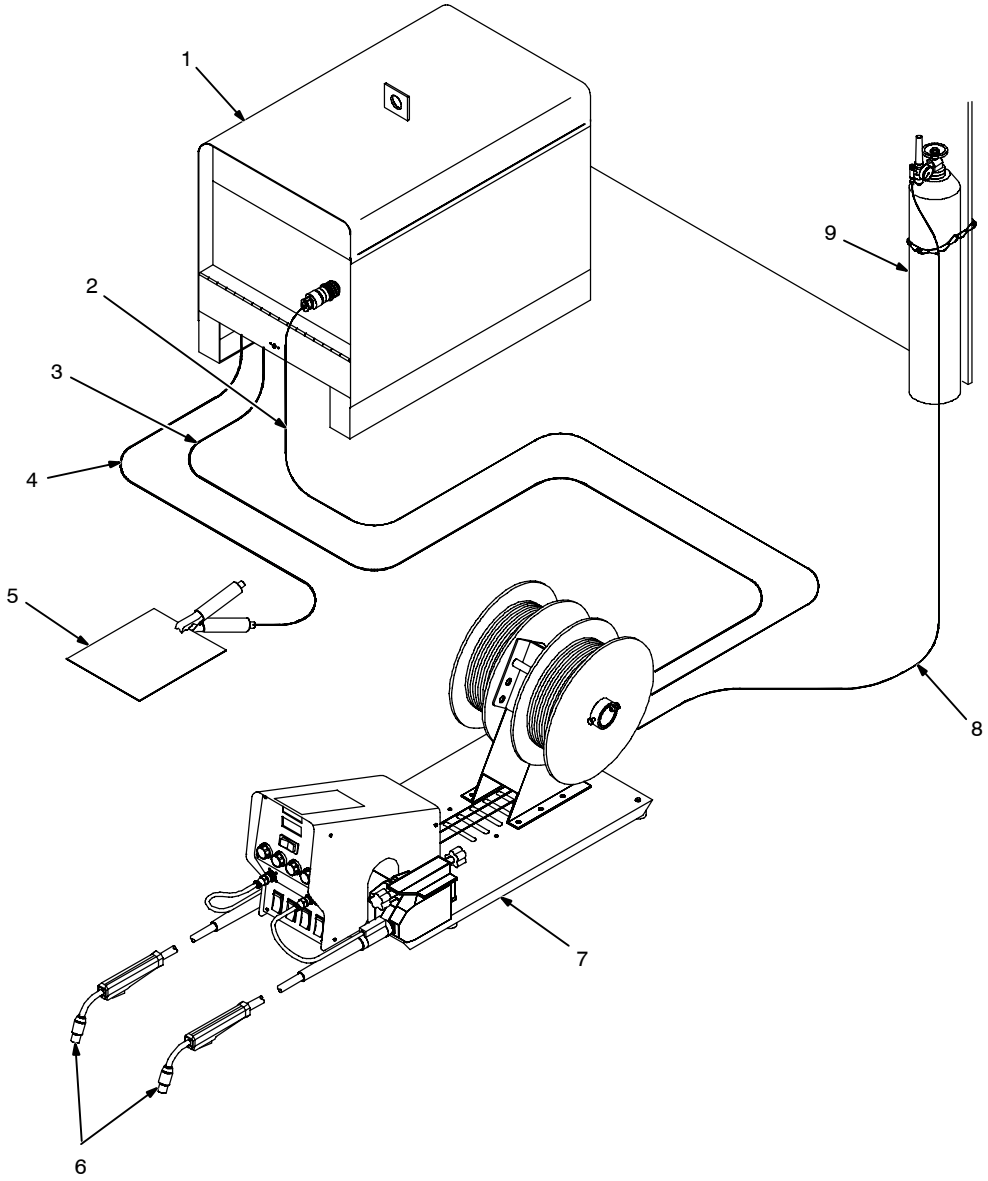
Ref. 803 048

5-4. Equipment Connection Diagrams



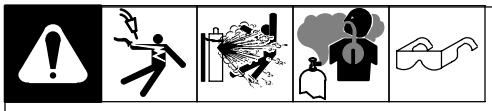
1 Welding Power Source
2 Contactor Control/Power Cord
3 Positive (+) Weld Cable
4 Negative (–) Weld Cable
5 Workpiece
6 Welding Gun
7 Wire Feeder
8 Gas Hose
9 Gas Cylinder and Regulator (Customer Supplied)

☞ *Shielding gas pressure not to exceed 100 PSI (689 kPa).*



803 068

5-5. Rear Panel Connections And Rotating Drive Assembly



1 14-Pin Control Cable - 10 Ft (3.0 m)

2 Shielding Gas Valve Fittings

Requires fitting with 5/8-18 right-hand threads. Connect customer-supplied gas hose.

3 Weld Cable Terminal

4 Jumper Weld Cable

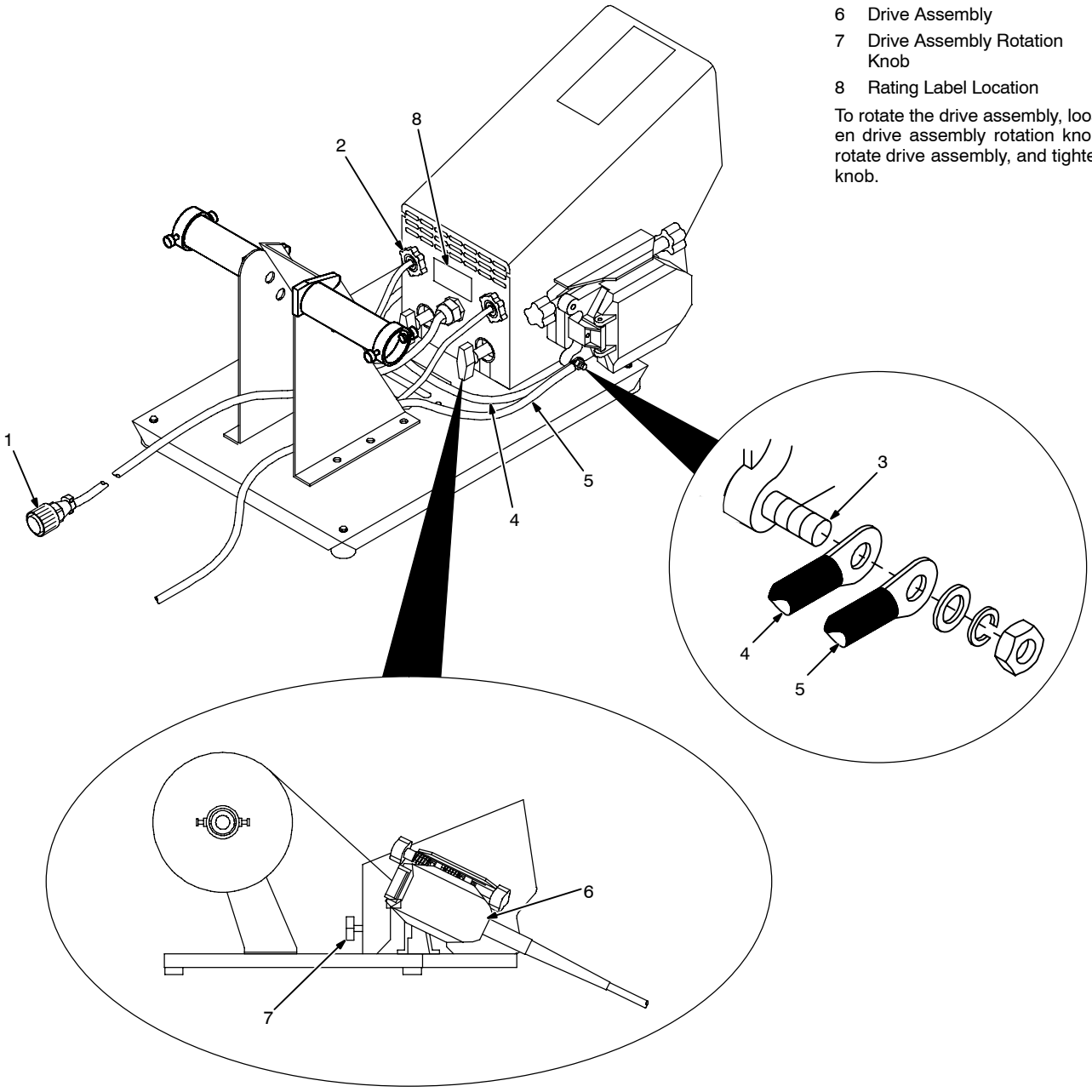
5 Weld Cable

6 Drive Assembly

7 Drive Assembly Rotation Knob

8 Rating Label Location

To rotate the drive assembly, loosen drive assembly rotation knob, rotate drive assembly, and tighten knob.



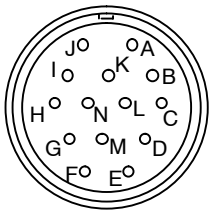
Tools Needed:

9/16, 5/8 in

3/16 in

803 067 / 802 825-A

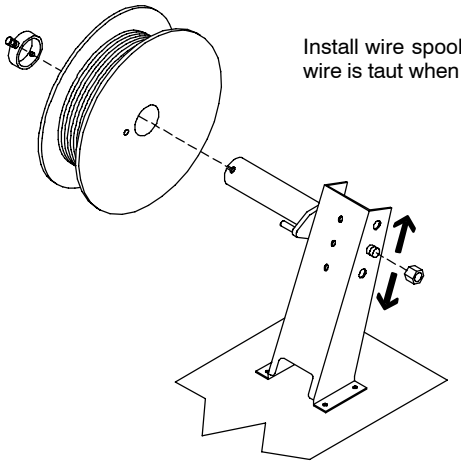
5-6. 14-Pin Plug Information

REMOTE 14	Pin*	Pin Information
	A	24 volts AC with respect to socket G.
	B	Contact closure to A completes 24 volts AC contactor control circuit.
	G	Circuit common for 24 volts AC circuit.
	C	+10 volts DC input from power source to wire feeder with respect to socket D.
	D	Remote control circuit common.
	E	0 to +10 volts DC output signal from wire feeder to power source with respect to socket D.
	H	Voltage feedback; 0 to +10 volts DC, 1 volt per 10 arc volts.
	F	Current feedback; 0 to +10 volts DC, 1 volt per 100 amperes.
*The remaining pins are not used.		

5-7. Wire Type, Size, And Feed Speed Capability Table

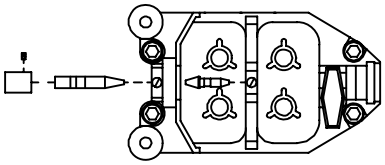
Motor Speed	Wire Type	Wire Size	Feed Speed Capability
Standard	All	.023 To 5/64 in. (0.6 To 2 mm)	50 To 780 ipm (1.2 To 19.8 mpm)
Standard	All	3/32 To 7/64 in. (2.4 To 2.8 mm)	50 To 700 ipm (1.2 To 17.8 mpm)
Standard	All	1/8 in. (3.2 mm)	50 To 300 ipm (1.2 To 7.6 mpm)
Optional High Speed	All	.023 To 5/64 in. (0.6 To 2 mm)	92 To 1435 ipm (2.3 To 36.4 mpm)

5-8. Installing And Threading Welding Wire

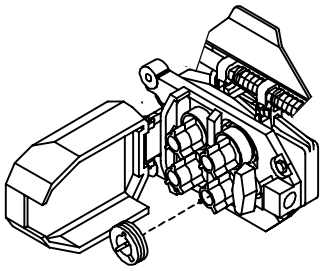


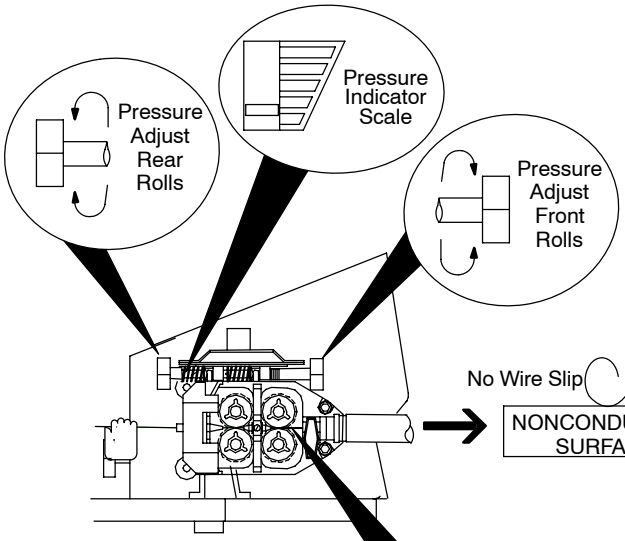
Install wire spool. Adjust tension nut so wire is taut when wire feed stops.

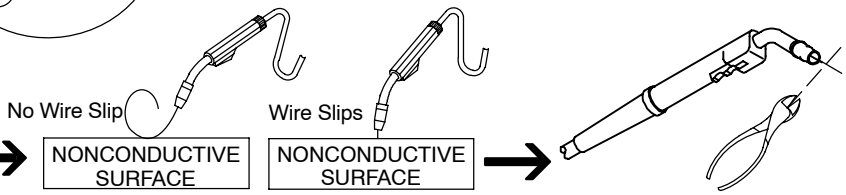
Install wire guides and anti-wear guide.

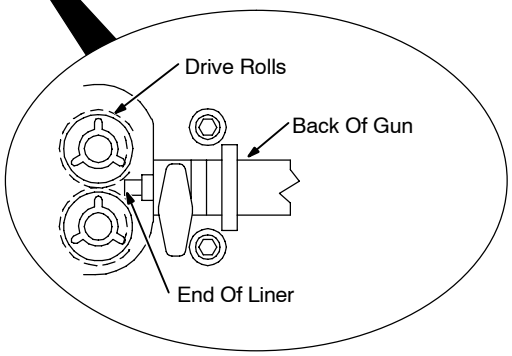


Install drive rolls.

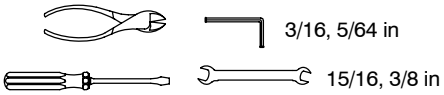








Tools Needed:



☞ *For best wire feeding performance, be sure that the outlet cable has the proper size liner for the welding wire size being used. Also, when the gun is installed, the liner extending from the back of the gun should be as close to the drive rolls as possible, without touching.*

Install gun. Lay gun cable out straight. Cut off end of wire. Push wire through guides up to drive rolls; continue to hold wire. Press Jog button to feed wire out gun.

☞ *For soft wire or small diameter stainless steel wire, reduce drive roll pressure on the rear roll to half that of the front rolls.*

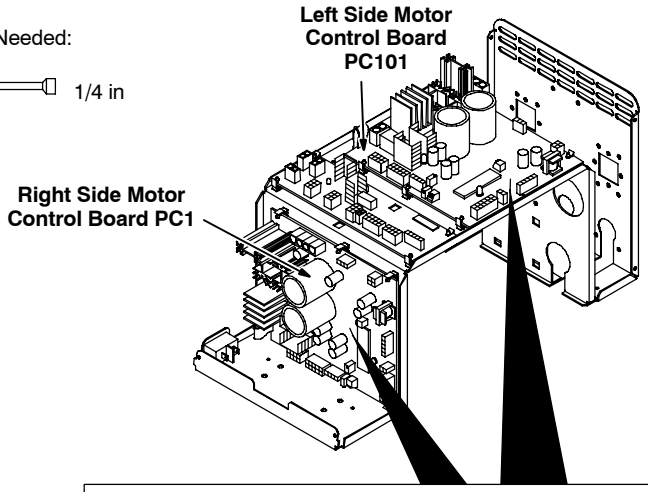
☞ To adjust drive roll pressure, hold nozzle about 2 in (51 mm) from nonconductive surface and press gun trigger to feed wire against surface. Tighten knob so wire does not slip. Do not overtighten. If contact tip is completely blocked, wire should slip at the feeder (see pressure adjustment above).Cut wire off. Close cover.

Ref. 156 929-A / Ref. 150 922 / Ref. 156 930 / S-0627-A

5-9. Setting Internal DIP Switches

Tools Needed:

1/4 in



Remove wrapper.

1 DIP Switch S1 On Motor Board PC1

- **Setting Current Detect Override (S1-1)**

Current detect override is used to disable run-in when a welding power source is used that doesn't provide current feedback through the 14-pin receptacle.

☞ *Pins F & H are not present in 14 pin receptacle on machines that don't provide current feedback.*

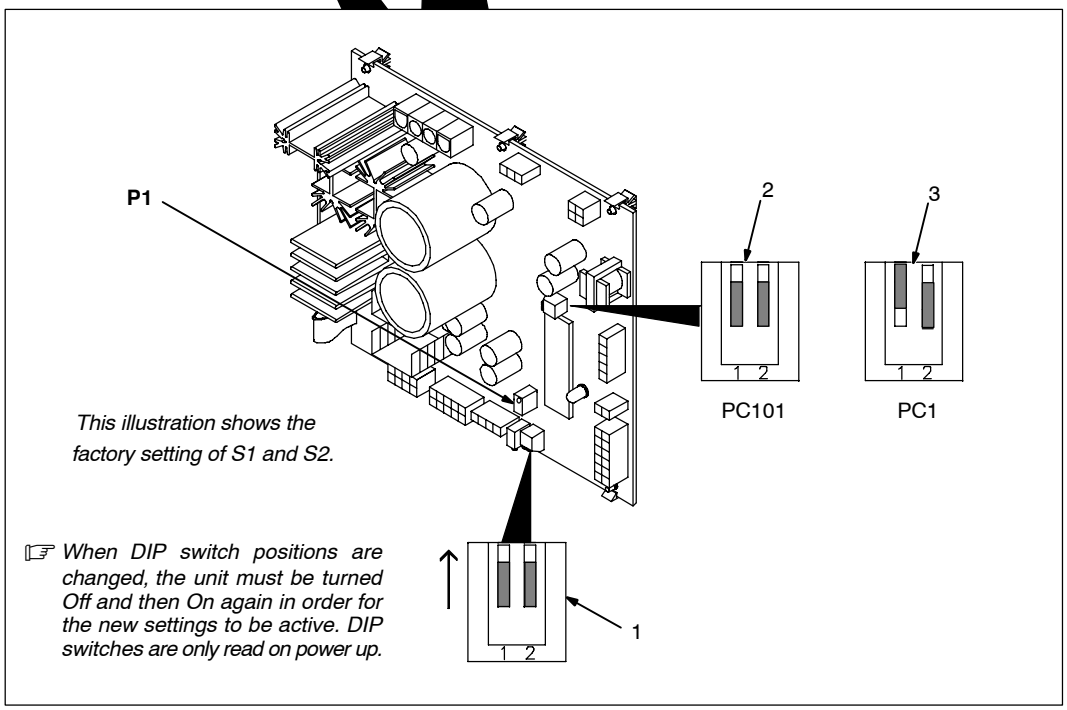
2 Set-Up DIP Switch S2 On PC101

Place S2 in position shown.

3 Set-Up DIP Switch On PC1

Place S2 in position shown.

Install wrapper when finished.

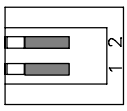


This illustration shows the factory setting of S1 and S2.

☞ *When DIP switch positions are changed, the unit must be turned Off and then On again in order for the new settings to be active. DIP switches are only read on power up.*

Position Settings And Results For DIP Switch S1 On PC1 And PC101

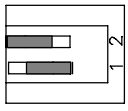
Automatic Run-In (ON) (Factory Default)



S1-1 And S1-2

On = Run-In speed is approximately 1/2 weld wire feed speed.

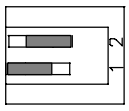
Automatic Run-In (OFF)



S1-1 And S1-2

Off = Run-In speed is set using potentiometer P1 located on Motor Board PC1.

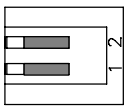
Current Detect Override (ON)



S1-1 And S1-2

On = Current detect override. For welding power sources that don't provide current feedback through the 14-pin receptacle. Run-in is inactive.

Current Detect Override (OFF) (Factory Default)

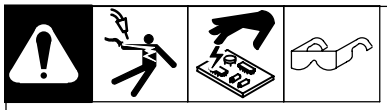


S1-1 And S1-2

Off = Current must be detected from power sources that provide current feedback through the 14-pin receptacle to go from run-in to welding condition. Run-in is active.

Ref. 805 407-A

5-10. Optional Equipment DIP Switch Settings

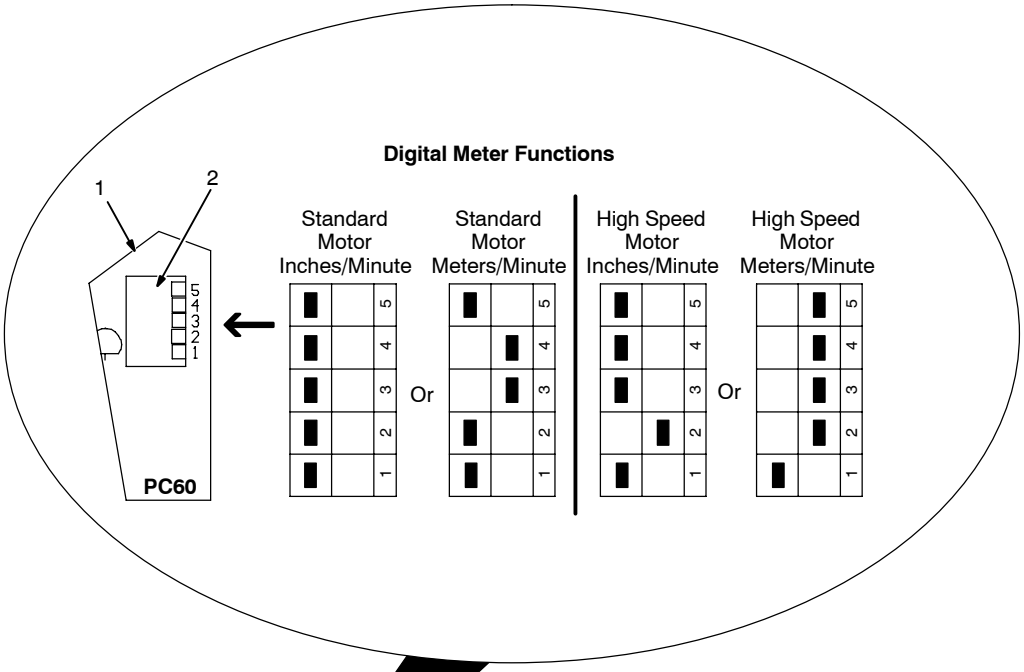


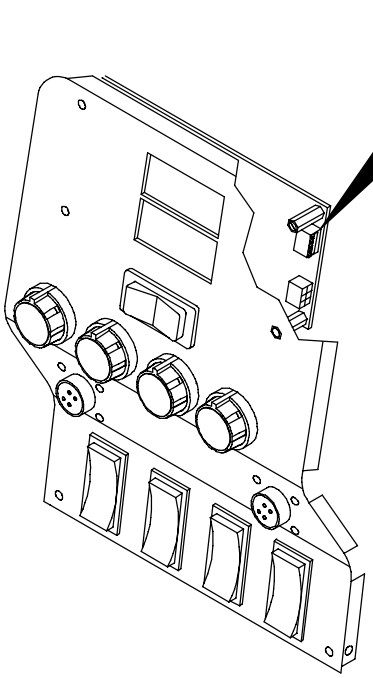
Remove wrapper.

1 Digital Meter Board PC60

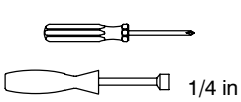
2 Meter Board Switch S2

Install wrapper when finished.





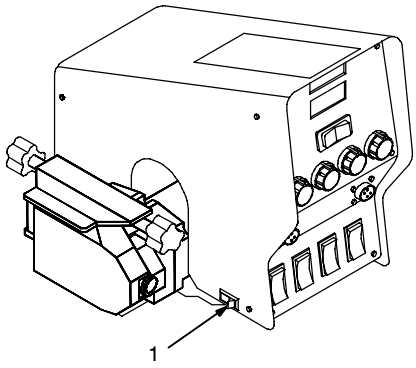
Tools Needed:



803 069

SECTION 6 – OPERATION

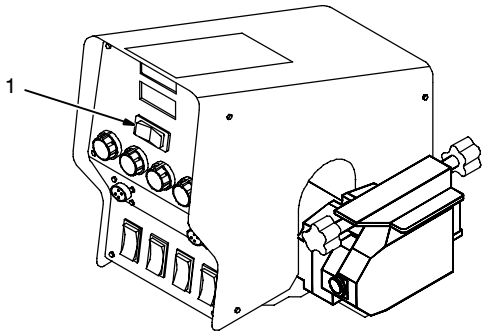
6-1. Power Switch



1 Power Switch

Ref. 803 065

6-2. Left/Right Select Switch

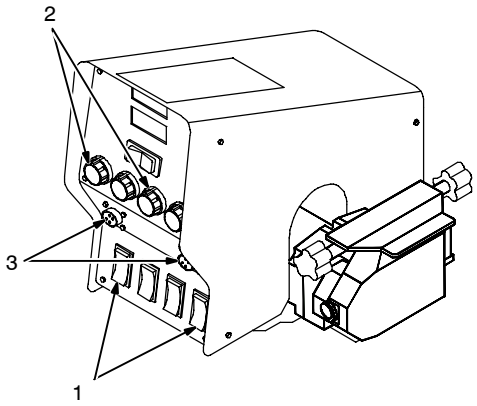


1 Left/Right Select Switch

Pressing the Left/Right Select switch allows the operator to choose which side of the unit's controls will operate.

Ref. 803 048

6-3. Jog/Purge



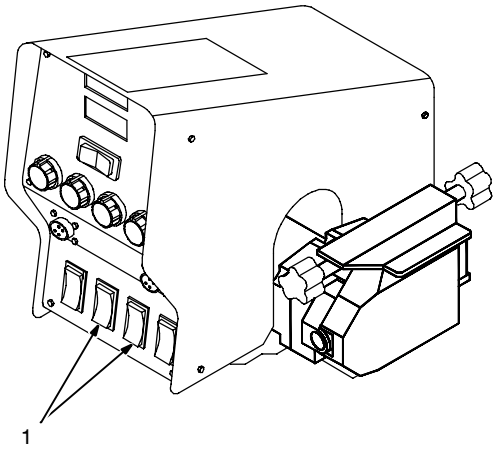
1 Jog/Purge Push Buttons
2 Wire Speed Controls
3 Gun Trigger Receptacles

Ref. 803 048

Pressing the Jog/Purge switch allows the operator to jog wire without energizing the weld power or gas valve circuit.

- The unit also provides the ability to jog the wire feeder by means of the gun trigger, however, the contactor is energized for 3 seconds.
- If the welding arc does not initiate in 3 seconds after the gun trigger is activated, the unit will perform a jog operation for a maximum of two minutes. If the gun trigger is still activated after two minutes, the jog operation is terminated to prevent complete despooling of the wire, as in the case of a damaged gun.
- Jog speed can be adjusted with the Wire Speed control when the unit is jogging wire. If equipped with meters, the unit displays jog speed while the unit is being jogged.
- Pressing the Jog/Purge button also allows the operator to purge gas lines before welding and to preset gas pressure at the regulator.

6-4. Trigger Hold Switch



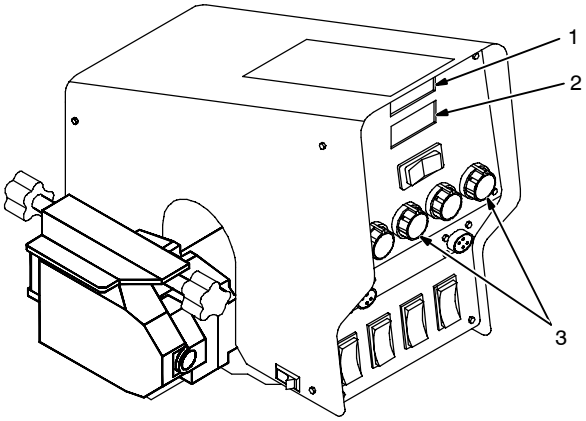
1 Trigger Hold Switches

Trigger hold allows the operator to weld without holding the gun trigger.

- To use the trigger hold function, place the trigger hold switch in the On position.
- The operator must hold the trigger for a minimum of 2 seconds, but not longer than 6 seconds before releasing it. Welding will continue when the trigger is released.
- To stop welding, press the trigger again.

Ref. 803 048

6-5. Voltage Control And Digital Meters



1 Voltmeter

Displays actual or preset voltage from welding power source through the 14–pin control cable.

2 Wire Speed Meter

Displays preset and actual wire feed speed while welding.

Factory set to display inches per minute. If display of meters per minute is desired, see Section 5-10.

3 Voltage Controls

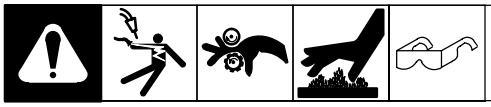
Use controls to adjust voltage output of welding power source.

☞ *You can adjust the preset voltage display on the wire feeder to match your power source's display by adjusting P2 on motor control board PC101 (left side), and/or P2 on motor control board PC1 (right side). See Section 7-2 for location of P2.*

Ref. 803 065

SECTION 7 – MAINTENANCE

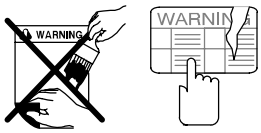
7-1. Routine Maintenance



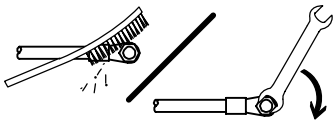
Disconnect power before maintaining.

3 Months

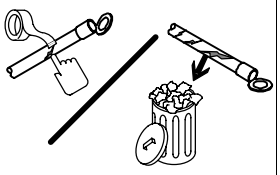
Replace unreadable labels.



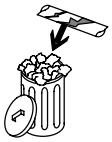
Clean and tighten weld terminals.



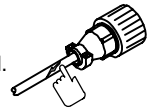
Repair or replace cracked weld cable.



Replace cracked parts.

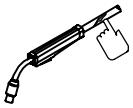


Check 14-pin cord.



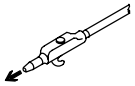
Check gas hose and fittings.

Check gun cable.

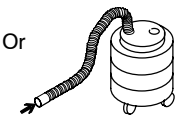


6 Months

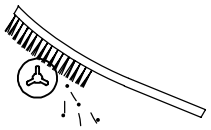
Blow out or vacuum inside. During heavy service, clean monthly.



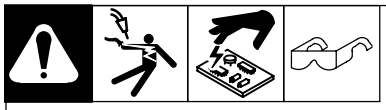
Or

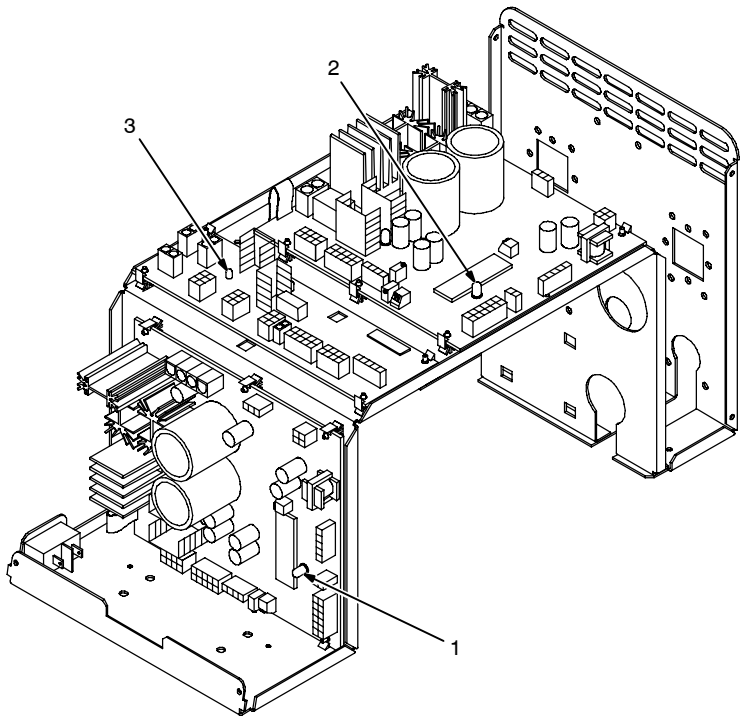


Clean drive rolls.



7-2. Diagnostics





1 LED3 On Right Side Motor Control Board PC1

2 LED3 On Left Side Motor Control Board PC101

3 LED3 On Dual Board PC70

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	Display On Optional Meter	LED3 Sequence	Indicated Error
Left Side Motor Control Board PC101	HELP 11	1 Blink	Communication Error
	HELP 12	2 Blinks	Trigger Error
	HELP 13	3 Blinks	Tach Error
	HELP 14	*4 Blinks	Motor Error
Right Side Motor Control Board PC1	HELP 21	1 Blink	Communication Error
	HELP 22	2 Blinks	Trigger Error
	HELP 23	3 Blinks	Tach Error
	HELP 24	*4 Blinks	Motor Error
Dual Board PC70	HELP 31	*4 Blinks	Communication Error
	*Since blink On time and blink Off time are equal in a four-blink cycle, the four–blink sequence appears as constant blinking.		

• **Error Indications**

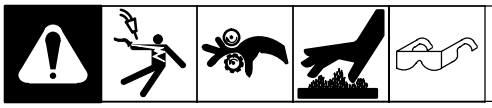
Error conditions are indicated by LED3 on PC1, PC101, PC70 or on display if meter option is present. To view LED3, turn Off unit, remove wrapper, and turn unit On. LED3 is most easily observed from the left side of the unit.

The LED blinks in a 2.5 second cycle. The number of blinks in this period indicates the type of error.

The priority of the errors is related to the number of blinks indicating the error. The more blinks, the more severe the error (motor error is top priority). A higher priority error overrides a lower one (if a motor error and a communication error existed, the light would blink four times for the motor error).

- **The communication error** occurs 2.5 seconds after a loss of communication between the motor and the optional meter board or Dual board. The user may continue to weld with this error. The error may be cleared by turning power Off, waiting a minimum of two seconds, and turning power On.
- **The trigger error** occurs if the user has the trigger held for more than two minutes without striking an arc (providing current override is not enabled), or if the user holds the trigger past the postflow phase in a timed weld. This error also occurs if the trigger is held when the feeder is powered up. The error may be cleared by releasing the trigger.
- **The tach error** occurs 2 seconds after the loss of tachometer feedback. The user may continue to weld with this error. The motor speed is regulated through the monitoring of voltage and current.
- **The motor error** indicates that the motor has been drawing too much current for too long.

7-3. Troubleshooting



Disconnect power before troubleshooting.

Trouble	Remedy
Wire feeds, shielding gas flows, but electrode wire is not energized.	Check cable connections. Check cables for continuity, and repair or replace cables if necessary (see Section 5-5).
Wire feeder is on, display does not light up, motor does not run, gas valve and welding power source contactor do not pull in.	Check and reset circuit breaker at welding power source.
Electrode wire feeding stops or feeds erratically during welding.	Check gun trigger connection. See gun Owner's Manual.
	Check gun trigger. See gun Owner's Manual.
	Readjust hub tension and drive roll pressure (see Section 5-8).
	Change to correct size drive roll (see Section 5-8).
	Clean or replace dirty or worn drive roll.
	Incorrect size or worn wire guides.
	Replace contact tip or liner. See gun Owner's Manual.
	Remove weld spatter or foreign matter from around nozzle opening.
	Have Factory Authorized Service Agency check drive motor or motor control board PC1.
Wire birdnests between feeder and gun.	Gun liner has to large of diameter opening, is clogged, or the end of the gun is not close enough to the front set of drive rolls.
Motor runs slowly.	Check for correct input voltage.
Wire feeder power is on, displays light up, but unit is inoperative.	Check welding gun trigger leads for continuity, and repair leads or replace gun.

Notes

SECTION 8 – ELECTRICAL DIAGRAM

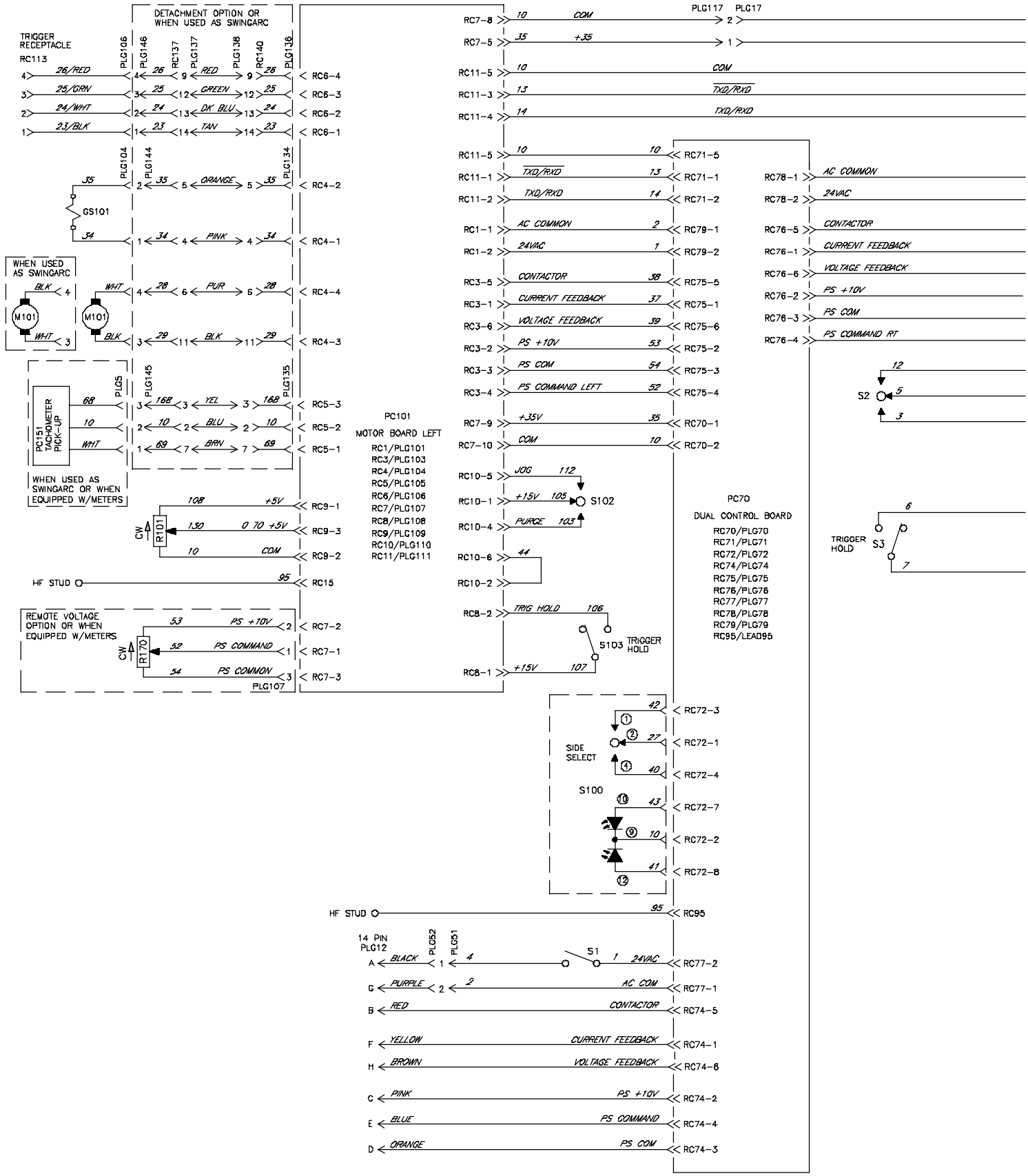
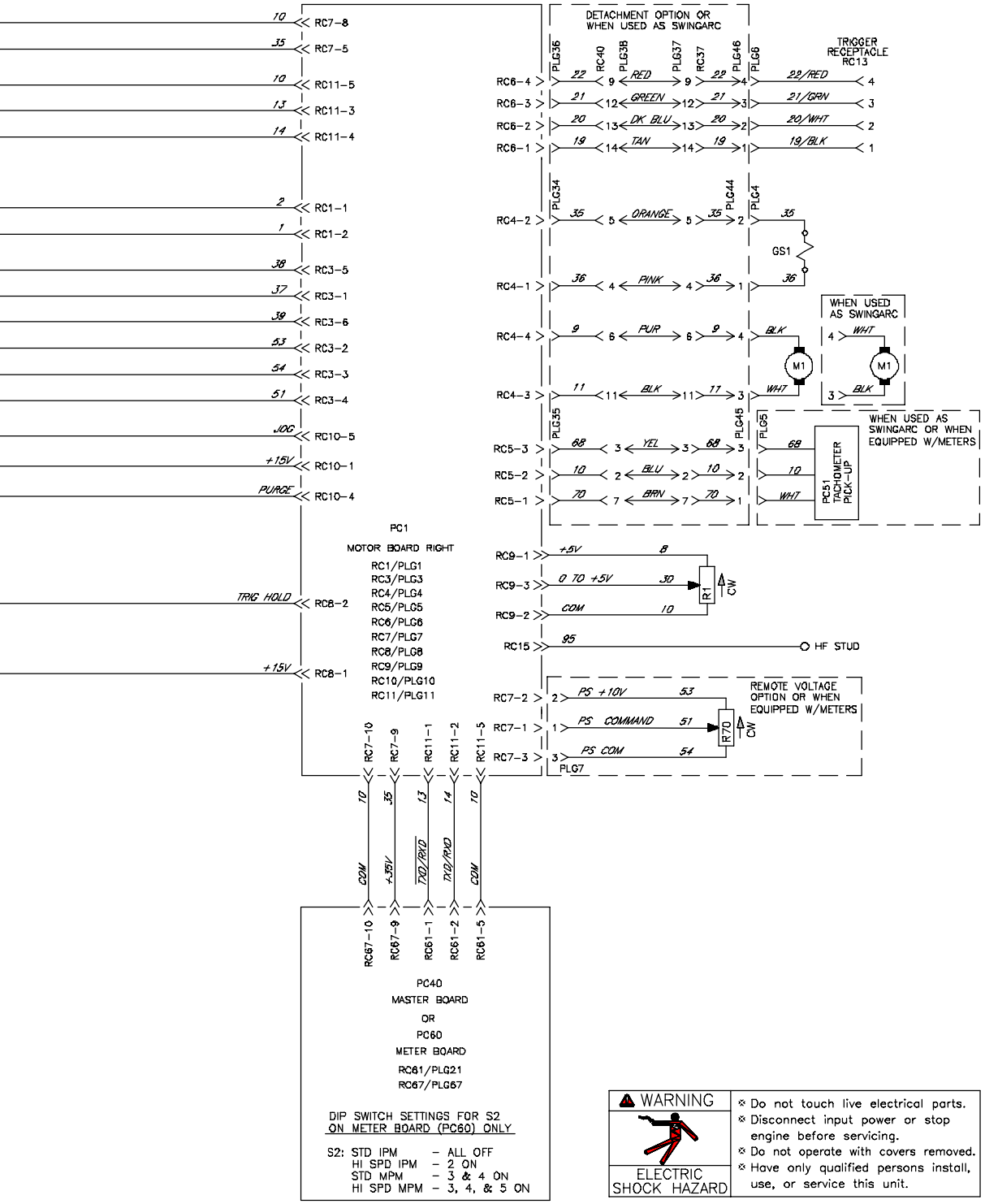


Figure 8-1. Circuit Diagram


DETACHMENT OPTION OR WHEN USED AS SWINGARC
TRIGGER RECEPTACLE RC13
PLG36
PLG38
PLG37
PLG46
PLG6
RC40
RC37
RC6-4
RC6-3
RC6-2
RC6-1
22/RED
21/GRN
20/WHT
19/BLK
RED
GREEN
DK BLU
TAN
PLG34
PLG44
PLG4
RC4-2
RC4-1
RC4-4
RC4-3
ORANGE
PINK
PUR
BLK
WHT
GS1
M1
WHEN USED AS SWINGARC
PLG35
PLG45
PLG5
RC5-3
RC5-2
RC5-1
YEL
BLU
BRN
PC51 TACHOMETER PICK-UP
WHEN USED AS SWINGARC OR WHEN EQUIPPED W/METERS
RC7-8
RC7-5
RC11-5
RC11-3
RC11-4
RC1-1
RC1-2
RC3-5
RC3-1
RC3-6
RC3-2
RC3-3
RC3-4
RC10-5
RC10-1
RC10-4
JOG
+15V
PURGE
TRIG HOLD
RC8-2
RC8-1
PC1
MOTOR BOARD RIGHT
RC1/PLG1
RC3/PLG3
RC4/PLG4
RC5/PLG5
RC6/PLG6
RC7/PLG7
RC8/PLG8
RC9/PLG9
RC10/PLG10
RC11/PLG11
RC9-1
RC9-3
RC9-2
+5V
0 TO +5V
COM
R1
CW
RC15
HF STUD
REMOTE VOLTAGE OPTION OR WHEN EQUIPPED W/METERS
RC7-2
RC7-1
RC7-3
PS +10V
PS COMMAND
PS COM
R70
PLG7
RC7-10
RC7-9
RC11-1
RC11-2
RC11-5
TXD/RXD
RXD/RXD
RC67-10
RC67-9
RC61-1
RC61-2
RC61-5
PC40
MASTER BOARD
OR
PC60
METER BOARD
RC61/PLG21
RC67/PLG67
DIP SWITCH SETTINGS FOR S2
ON METER BOARD (PC60) ONLY
S2: STD IPM – ALL OFF
HI SPD IPM – 2 ON
STD MPM – 3 & 4 ON
HI SPD MPM – 3, 4, & 5 ON
WARNING
ELECTRIC SHOCK HAZARD
Do not touch live electrical parts.
Disconnect input power or stop engine before servicing.
Do not operate with covers removed.
Have only qualified persons install, use, or service this unit.

204 716-B

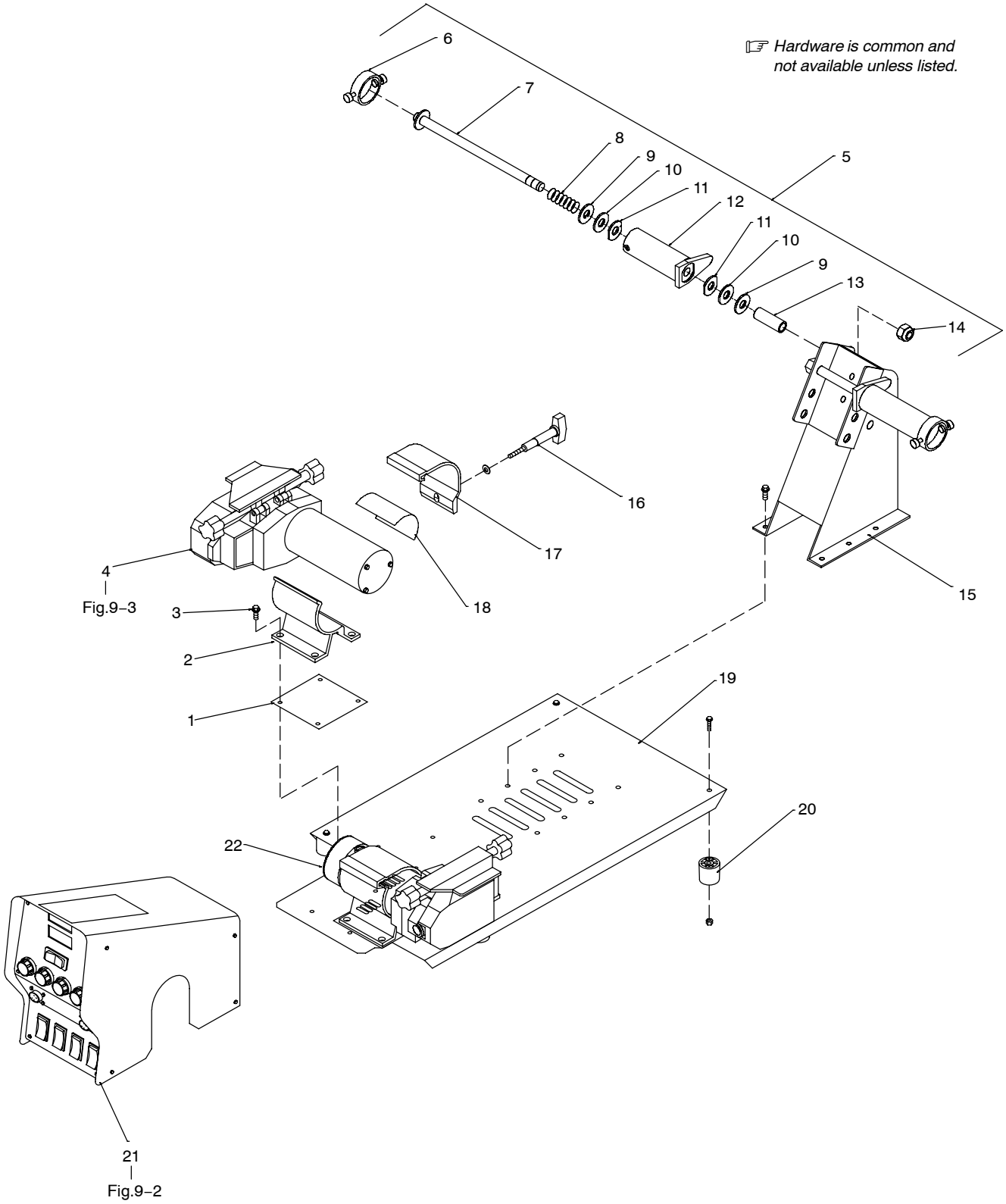


Figure 9-1. Main Assembly

Item No.	Part No.	Description	Quantity

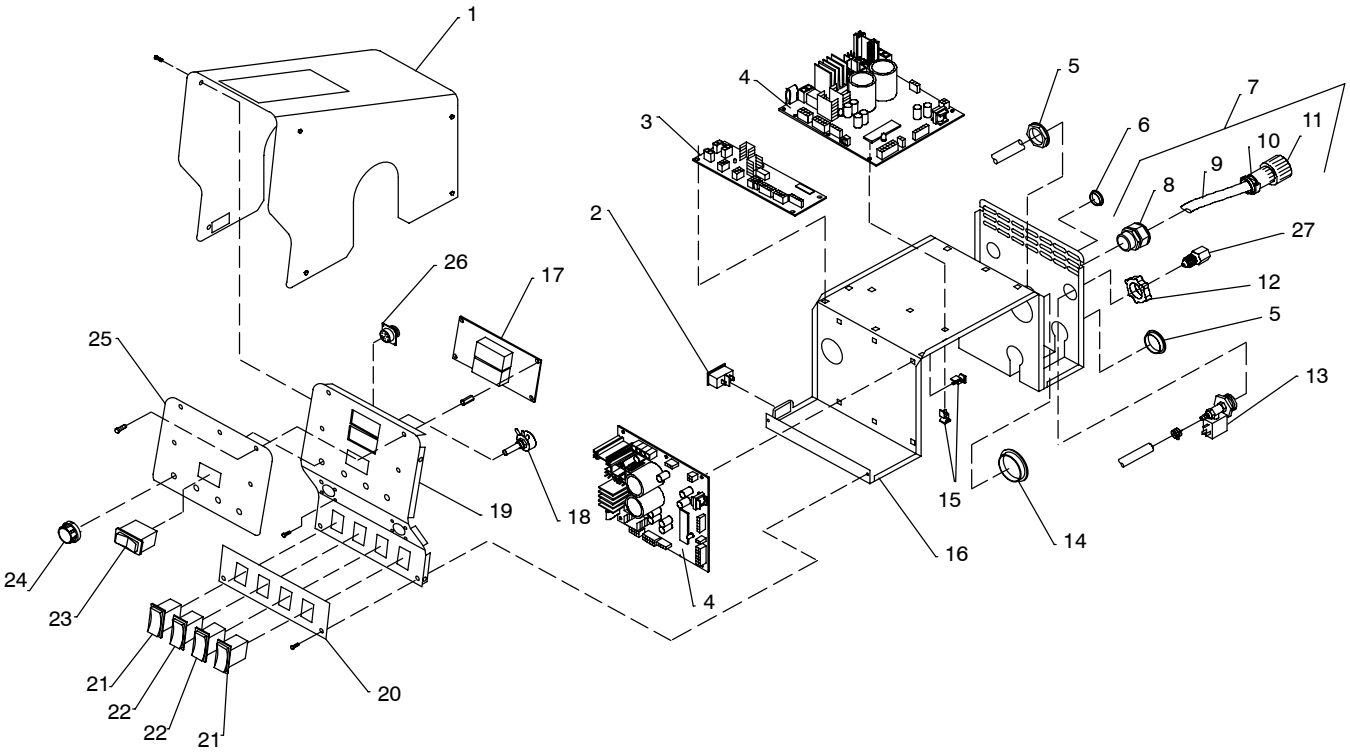
Figure 9-1. Main Assembly

1	159 647	Insulator, Motor Clamp	2
2	159 646	Clamp, Motor Base	2
3	159 360	Insulator, Screw Machine	8
4	201 761	Drive Assy, Wire S/L 4 Roll	1
4	201 763	Drive Assy,Wire S/L 4 Roll Hi−Speed W/Tach	1
5	143 160	Hub+Spindle Assy, (Consisting Of)	2
6	058 427	Ring, Retaining Spool	1
7	180 576	Shaft, Support Spool	1
8	010 233	Spring, Cprsn .970 Od X .120 Wire X 1.250pld	1
9	057 971	Washer, Flat Stl Keyed 1.500 Dia X .125thk	2
10	010 191	Washer, Fbr .656 Id X 1.500 Od X .125thk	2
11	058 628	Washer, Brake Stl	2
12	058 428	Hub, Spool	1
13	071 730	Tubing, STL .875 Od X 12Ga Wall X 2.500	2
14	135 205	Nut, Stl Slflkg Hex Reg .625-11 W/Nylon Insert	1
15	141 411	Support, Spool	1
16	208 339	Extension, Dual Clamp L.H.	1
16	208 338	Extension, Dual Clamp R.H.	1
17	156 243	Clamp, Motor Top	2
18	145 639	Strip, Buna−n .062 X 3.000 X 4.000 Compressed Sht	2
19	139 226	Base	1
20	134 306	Foot, Rubber 1.250 Dia X 1.375 High No 10 Screw	4
21		Control Box (Refer to Figure 9-2)	1
22	201 767	Drive Assy, Wire R 4 Roll	1
22	201 769	Drive Assy,Wire R 4 Roll Hi−Speed W/Tach	1
	164 059	Hose, Gas	1

+When ordering a component originally displaying a precautionary label, the label should also be ordered.

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.

☞ *Hardware is common and not available unless listed.*



805 427-A

Figure 9-2. Control Box

Item No.	Dia. Mkgs.	Part No.	Description	Quantity Model D-74S	Quantity Model D-74D
			Figure 9-2. Control Box (Figure 9-1 Item 21)		
1		204 722	Wrapper, Feeder	1	1
		238 487	Label, Warning General Precautionary (CE/Domestic)	1	1
2	S1	111 997	Switch, Rocker Spst 10A 250VAC On-Off Visi Red Rock	1	1
3	PC70	237 752	Circuit Card Assy, Dual W/Program	1	1
4	PC1, PC101	238 469	Circuit Card Assy, Motor Control W/Program	2	2
5		030 170	Bushing, Snap−in Nyl .750 Id X 1.000 Mtg Hole	2	2
6		000 527	Blank, Snap−in Nyl .875 Mtg Hole Black	1	1
7		200 196	Cable, Power 11.5ft 8/C 2-14Ga 6-18Ga (Consisting Of)	1	1
8		139 041	Strain Relief	1	1
9		163 519	Cable, Port	11.5 Ft (3.5 m)	
10		079 739	Conn, Circ Cpc Clamp Str Rlf	1	1
11	PLG12	141 162	Housing Plug+Pins, (Service Kit)	1	1
	PLG52	174 823	Housing Plug Pins+Skts, (Service Kit)	1	1
	PLG74	115 093	Housing Plug+Skts, (Service Kit)	1	1
12		605 227	Nut, 750−14 Knurled1.68Dia .41H Nyl	2	2
13	GS1, GS101	228 035	Valve, 34VDC 1Way .750−14 Thd 2mm Orf 100PSI	2	2
14		010 494	Bushing, Snap−in Nyl 1.375 Id X 1.750 Mtg Hole	2	2
15		134 201	Stand−off Support, PC Card .312/.375w/Post&lock .43	17	17
16		235 217	Enclosure, Control	1	1
17	PC60	239 934	Circuit Card Assy, Meter W/Program	0	1
17	PC40	239 937	Circuit Card Assy, Master W/Program S-74D	1	0

Item No.	Dia. Mkgs.	Part No.	Description	Quantity Model D-74S	Quantity Model D-74D

Figure 9-2. Control Box (Continued)

18	R1, R101	073 562	Potentiometer, Cp Std Slot 1t 2. W 10k Linear D-74S	2	0
18	R1, 101, 70, 170	224 597	Potentiometer, Cermet Std Flat 3.75t 2 W 10k Linear D-74D	0	4
19		204 723	Panel, Front	1	1
20		204 724	Nameplate, Miller Lower	1	1
20		207 428	Nameplate, Lower (CE Version)	1	1
21	S2, S102	200 295	Switch, Rocker Spdt 15A 12V (On)–Off–(On)	2	2
22	S3, S103	201 642	Switch, Rocker Spdt 15A 12V On–None–on	2	2
23	S100	201 641	Switch, Rocker Spdt 15A 12V (On)–Off–(On) W/Leds	1	1
24		193 919	Knob, Pointer 1.250 Dia X .250 Id W/Two Set Screws	4	4
25		206 513	Nameplate, Miller D-74S Upper	1	0
25		206 511	Nameplate, Miller D-74D Upper	0	1
25		207 431	Nameplate, Upper (CE Version) D-74S	1	0
25		207 433	Nameplate, Upper (CE Version) D-74D	0	1
26	RC13, RC113	048 282	RCPT W/Skts, (Service Kit)	2	2
27		211 989	Fitting, W/Screen	2	2

+When ordering a component originally displaying a precautionary label, the label should also be ordered.

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.

Dia. Mkgs.	Part No.	Description	Quantity

Harness Connectors/Receptacles

PLG6,106	115 094	Housing Plug+Skts, (Service Kit)	1
PLG4,104	136 810	Housing Plug+Skts, (Service Kit)	1
PLG72	115 092	Housing Plug+Skts, (Service Kit)	1
PLG9,109	201 665	Housing Plug+Skts, (Service Kit)	1
PLG11, 21,71,111	131 055	Housing Rcpt+Skts, (Service Kit)	1
PLG7,67,107	115 091	Housing Plug+Skts, (Service Kit)	1
PLG17,70	158 719	Housing Plug+Skts, (Service Kit)	1
PLG117	165 404	Housing Rcpt+Skts, (Service Kit)	1
PLG1,77,78,79,101	202 592	Housing Plug+Skts, (Service Kit)	1
PLG3,75,76,103	115 093	Housing Plug+Skts, (Service Kit)	1
PLG51	174 824	Housing Plug Pins+Skts, (Service Kit)	1
PLG8,108	131 054	Housing Rcpt+Skts, (Service Kit)	1
PLG10,110	130 203	Housing Plug+Skts, (Service Kit)	1

☞ *Hardware is common and not available unless listed.*

See Table 9-1 For Drive Roll & Wire Guide Kits

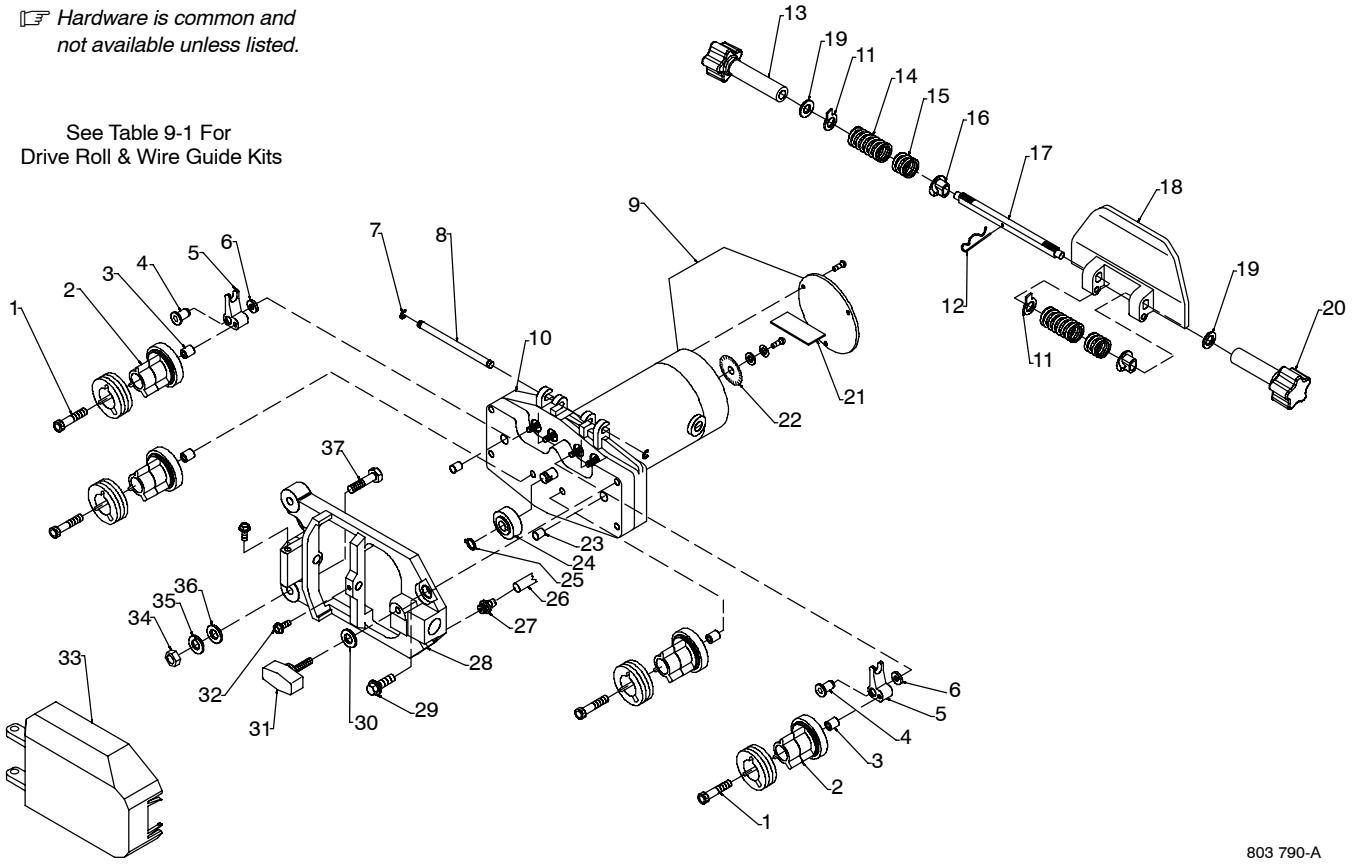


Figure 9-3. Drive Assembly, Wire

Item No.	Dia. Mkgs.	Part No.	Description	Quantity Model D-74S	Quantity Model D-74D
			Figure 9-3. Drive Assembly, Wire (Figure 9-1 Item 4)		
1		010 668	.. Screw, Cap Stl Sch .250-20 X 1.500	4	4
2		172 075	.. Carrier, Drive Roll W/Components	4	4
3		149 962	.. Spacer, Carrier Drive Roll	4	4
4		149 486	.. Pin, Rotation Arm Rocker	2	2
5		132 750	.. Arm, Pressure	2	2
6		150 520	.. Spacer, Flat Stl .257 Id X .619 Od X .105	2	2
7		133 493	.. Ring, Retaining Ext .250 Shaft X .025thk	2	2
8		133 350	.. Pin, Hinge	1	1
9	M1,101	201 230	.. Motor, Gear 1/8HP 24VDC Standard Speed	1	1
9	M1,101	201 231	.. Motor, Gear 1/8HP 24VDC High Speed	1	1
		153 491	.... Kit, Brush Replacement (Consisting Of)	1	1
		153 492	..... Cap, Brush	2	2
		*153 493	..... Brush, Carbon	2	2
		184 136	.... Kit, Brush Holder Replacement	1	2
10		155 098	.. Kit, Cover Motor Gearbox (Consisting Of)	1	1
		153 550	.... Cover, Motor Gearbox (Consisting Of)	1	1
		155 099	..... Gasket, Cover	1	1
		155 100	..... Screw, Cover	5	5
		154 031	.... Spacer, Locating	2	2
		133 493	.... Ring, Rtng Ext .250 Shaft Grv X .025thk	1	1

Item No.	Dia. Mkgs.	Part No.	Description	Quantity Model D-74S	Quantity Model D-74D
			Figure 9-3. Drive Assembly, Wire (Continued)		
		203 642	. . Pressure Arm, R & Vert L 4 Roll (Consisting Of)	1	1
		203 631	. . Pressure Arm, S/L & Vert S/R 4 Roll (Consisting Of)	1	1
11		203 641	. . . . Washer, Flat Indicator Spring Tension	2	2
12		182 415	. . . . Pin, Cotter Hair	1	1
13		203 640	. . . . Knob, W/Extension Short Pressure Arm	1	1
14		182 156	. . . . Spring, Cprsn	2	2
15		182 155	. . . . Spring	2	2
16		132 746	. . . . Bushing, Spring	2	2
17		203 633	. . . . Shaft, Spring	1	1
18		203 632	. . . . Carrier, Shaft	1	1
19		133 739	. . . . Washer, Flat Buna .375 Id X .625 Od X .062thk	2	2
20		203 637	. . . . Knob, W/Extension Long Pressure Arm	1	1
21	PC51,151	237 048	. . Circuit Card, Digital Tach (Consisting Of)	0	2
	PLG5	131 204	. . . . Connector & Sockets	0	1
		604 311	. . . . Grommet, Rbr .250 Id X .375Mtg Hole .062 Groove	0	1
22		132 611	. . Optical Encoder Disc	0	1
		603 115	. . Weather Stripping, Adh .125 X .375	0	1
23		167 387	. . Spacer, Locating	2	2
24		168 825	. . Drive, Pinion	1	2
25		133 308	. . Ring, Retaining Ext .375 Shaft X .025thk	1	1
26		134 834	. . Hose, Sae .187 Id X .410 Od (Order By Ft)	2 Ft (0.6 m)	
27		149 959	. . Fitting, Brs Barbed M 3/16tbg X .312-24	1	1
28		179 265	. . Adapter, Gun/Feeder LH	1	1
28		179 264	. . Adapter, Gun/Feeder RH	1	1
29		108 940	. . Screw, Cap Stl Hexhd .250-20 X .750	4	4
30		604 538	. . Washer, Flat Stl Sae .312	1	1
31		151 437	. . Knob, Plstc T 1.125 Lg X .312-18 X 1.500	1	1
32		151 290	. . Screw, Mach Stl Hexwhd 10-32 X .500	2	2
33		179 277	. . Cover, Drive Roll (Consisting Of)	1	1
		178 937	. . . . Label, Warning Electric Shock	1	1
34		601 872	. . Nut, Stl Hex Full Fnsh .375-16	1	1
35		602 213	. . Washer, Lock Stl Split .375	1	1
36		602 243	. . Washer, Flat Stl Std .375	1	1
37		601 966	. . Screw, Cap Stl Hexhd .375-16 X 1.250	1	1

*Recommended Spare Parts.

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.

Table 9-1. Drive Roll And Wire Guide Kits

	"V" GROOVE FOR HARD WIRE	"U" GROOVE FOR SOFT–SHELLED CORED WIRES	"V" KNURLED FOR HARD–SHELLED CORED WIRES	"U" COGGED FOR EXTREMELY SOFT WIRE OR SOFT – SHELLED CORED WIRES	"U" GROOVE FOR ALUMINUM WIRES CONTAINS NYLON WIRE GUIDES
WIRE SIZE					
.023/.025 in. (0.6 mm)	**151024**				
.030 in. (0.8 mm)	**151025**				
.035 in. (0.9 mm)	**151026**		**151052**		**243233**
.040 in. (1.0 mm)	**161190**				
.045 in. (1.1/1.2 mm)	**151027**	**151037***	**151053**	**151070**	**243234***
.052 in. (1.3/1.4 mm)	**151028**	**151038**	**151054**	**151071**	
1/16 in. (1.6 mm)	**151029**	**151039**	**151055**	**151072**	**243235**
.068/.072 in. (1.8 mm)			**151056**		
5/64 in. (2.0 mm)		**151040**	**151057**	**151073**	
3/32 in. (2.4 mm)		**151041**	**151058**	**151074**	
7/64 in. (2.8 mm)		**151042**	**151059**	**151075**	
1/8 in. (3.2 mm)		**151043****	**151060****	**151076****	
*Accommodates .045 and .047 (3/64 in) wire **Requires a low –speed wire feeder					

Wire Guides			**Nylon Wire Guides for Feeding Aluminum Wire**		
Wire Sizes	Inlet Guide	Intermediate Guide	Wire Size	Inlet Guide	Intermediate Guide
.023 to .040 in. (0.6 to 1.0mm)	221030	149518	.035 in. (0.9mm)	221912	242417
.045 to .052 in. (1.1 to 1.4mm)	221030	149519	.047 in. (1.2mm)	221912	205936
1/16 to 5/64 in. (1.6 to 2mm)	221030	149520	1/16 in. (1.6mm)	221912	205937
3/32 to 7/64 in. (2.4 to 2.8mm)	229919	149521			
1/8 in. (3.2mm)	229919	149522			

Warranty Questions?

Call
1-800-4-A-MILLER
for your local
Miller distributor.

Your distributor also gives you ...

Service
You always get the fast, reliable response you need. Most replacement parts can be in your hands in 24 hours.

Support
Need fast answers to the tough welding questions? Contact your distributor. The expertise of the distributor and Miller is there to help you, every step of the way.

Miller

TRUE BLUE® WARRANTY

Effective January 1, 2009
(Equipment with a serial number preface of LK or newer)

This limited warranty supersedes all previous Miller warranties and is exclusive with no other guarantees or warranties expressed or implied.

LIMITED WARRANTY – Subject to the terms and conditions below, Miller Electric Mfg. Co., Appleton, Wisconsin, warrants to its original retail purchaser that new Miller equipment sold after the effective date of this limited warranty is free of defects in material and workmanship at the time it is shipped by Miller. THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS.

Within the warranty periods listed below, Miller will repair or replace any warranted parts or components that fail due to such defects in material or workmanship. Miller must be notified in writing within thirty (30) days of such defect or failure, at which time Miller will provide instructions on the warranty claim procedures to be followed.

Miller shall honor warranty claims on warranted equipment listed below in the event of such a failure within the warranty time periods. All warranty time periods start on the delivery date of the equipment to the original end-user purchaser, and not to exceed one year after the equipment is shipped to a North American distributor or eighteen months after the equipment is shipped to an International distributor.

1. 5 Years Parts — 3 Years Labor
   * Original main power rectifiers only to include SCRs, diodes, and discrete rectifier modules
2. 3 Years — Parts and Labor
   * Transformer/Rectifier Power Sources
   * Plasma Arc Cutting Power Sources
   * Process Controllers
   * Semi-Automatic and Automatic Wire Feeders
   * Inverter Power Sources (Unless Otherwise Stated)
   * Water Coolant Systems (Integrated)
   * Intellitig
   * Engine Driven Welding Generators **(NOTE: Engines are warranted separately by the engine manufacturer.)**
3. 1 Year — Parts and Labor Unless Specified
   * Motor Driven Guns (w/exception of Spoolmate Spoolguns)
   * Positioners and Controllers
   * Automatic Motion Devices
   * RFCS Foot Controls
   * Induction Heating Power Sources, Coolers, and Electronic Controls/Recorders
   * Water Coolant Systems (Non-Integrated)
   * Flowgauge and Flowmeter Regulators (No Labor)
   * HF Units
   * Grids
   * Spot Welders
   * Load Banks
   * Fume Extractors
   * Arc Stud Power Sources & Arc Stud Guns
   * Racks
   * Running Gear/Trailers
   * Plasma Cutting Torches (except APT & SAF Models)
   * Field Options (NOTE: Field options are covered under True Blue® for the remaining warranty period of the product they are installed in, or for a minimum of one year — whichever is greater.)
   * Bernard-Branded Mig Guns (No Labor)
   * Weldcraft-Branded TIG Torches (No Labor)
   * Subarc Wire Drive Assemblies
4. 6 Months — Batteries
5. 90 Days — Parts
   * MIG Guns and Subarc (SAW) Guns
   * Induction Heating Coils and Blankets, Cables, and Non-Electronic Controls
   * APT & SAF Model Plasma Cutting Torches
   * Remote Controls
   * Accessory (Kits)
   * Replacement Parts (No labor)
   * Spoolmate Spoolguns
   * Canvas Covers

Miller's True Blue® Limited Warranty shall not apply to:

1. **Consumable components; such as contact tips, cutting nozzles, contactors, brushes, slip rings, relays or parts that fail due to normal wear. (Exception: brushes, slip rings, and relays are covered on Bobcat, Trailblazer, and Legend models.)**
2. Items furnished by Miller, but manufactured by others, such as engines or trade accessories. These items are covered by the manufacturer's warranty, if any.
3. Equipment that has been modified by any party other than Miller, or equipment that has been improperly installed, improperly operated or misused based upon industry standards, or equipment which has not had reasonable and necessary maintenance, or equipment which has been used for operation outside of the specifications for the equipment.

MILLER PRODUCTS ARE INTENDED FOR PURCHASE AND USE BY COMMERCIAL/INDUSTRIAL USERS AND PERSONS TRAINED AND EXPERIENCED IN THE USE AND MAINTENANCE OF WELDING EQUIPMENT.

In the event of a warranty claim covered by this warranty, the exclusive remedies shall be, at Miller's option: (1) repair; or (2) replacement; or, where authorized in writing by Miller in appropriate cases, (3) the reasonable cost of repair or replacement at an authorized Miller service station; or (4) payment of or credit for the purchase price (less reasonable depreciation based upon actual use) upon return of the goods at customer's risk and expense. Miller's option of repair or replacement will be F.O.B., Factory at Appleton, Wisconsin, or F.O.B. at a Miller authorized service facility as determined by Miller. Therefore no compensation or reimbursement for transportation costs of any kind will be allowed.

TO THE EXTENT PERMITTED BY LAW, THE REMEDIES PROVIDED HEREIN ARE THE SOLE AND EXCLUSIVE REMEDIES. IN NO EVENT SHALL MILLER BE LIABLE FOR DIRECT, INDIRECT, SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES (INCLUDING LOSS OF PROFIT), WHETHER BASED ON CONTRACT, TORT OR ANY OTHER LEGAL THEORY.

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Owner's Record

Please complete and retain with your personal records.

Model Name	Serial/Style Number
Purchase Date	(Date which equipment was delivered to original customer.)
Distributor	
Address	
City	
State	Zip

For Service

Contact a DISTRIBUTOR or SERVICE AGENCY near you.

Always provide Model Name and Serial/Style Number.

Contact your Distributor for:	Welding Supplies and Consumables Options and Accessories Personal Safety Equipment Service and Repair Replacement Parts Training (Schools, Videos, Books) Technical Manuals (Servicing Information and Parts) Circuit Diagrams Welding Process Handbooks To locate a Distributor or Service Agency visit www.millerwelds.com or call 1-800-4-A-Miller
Contact the Delivering Carrier to:	File a claim for loss or damage during shipment. For assistance in filing or settling claims, contact your distributor and/or equipment manufacturer's Transportation Department.

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